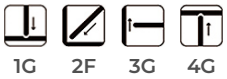
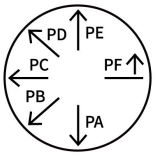
SW-308LT

Classification

AWS AWS A5.22/ ASME SFA-5.22 E308LT1-1/-4
JIS Z 3323 TS308L-FB1
EN ISO 17633-A-T 19 9 L P M21/C1 2

Welding Positions





Features

- Good impact value at cryogenic temperatures
- Good performance in all positions

Polarity

DC+

Application Areas

- 18%Cr-8%Ni stainless steel
- Cryogenic service such as LNG storage tank

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Cu	Ni	Cr	Mo
100% CO2	0.02	0.8	1.5	0.015	0.010	0.09	10.7	18.4	0.02
Ar+20~25% CO2	0.02	0.8	1.5	0.015	0.010	0.08	9.7	18.4	0.02

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	567(81)	48	-60(-75) -196(-320)	36(27) 34(25)
Ar+20~25% CO2	573(83)	48	-60(-75) -196(-320)	38(28) 36(26)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	140~210	Spool 5kg(11lbs), 12.5(27.6lbs), 15kg(33lbs)