

CSF-308L(P)

For 18%Cr-8%Ni Stainless steel

AWS A5.22 E308LT0(1)-1/-4

Applications

CSF-308L(P) is suitable for Welding of low carbon 18%Cr-8%Ni Stainless steel(SUS308L).

Characteristics

- (1) CSF-308L(P) is flux cored wire and designed for Fillet & H-F(All-position) welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 100%CO₂ or Ar+CO₂ gas.

Notes on usage

- (1) The optimum flow of CO₂ for Shielding is 20~25 ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 1/2~1 inch.

Typical chemical composition of weld metal (%)

(Shielding gas :100%CO₂)

	C	Mn	Si	P	S	Cr	Ni	FN
CSF-308L	0.03	1.35	0.65	0.025	0.010	19.3	9.6	8
CSF-308LP	0.03	1.45	0.60	0.020	0.007	20.0	9.8	10
CSF-308LP(Cryogenic)	0.03	1.43	0.60	0.020	0.009	19.5	10.2	6

Typical mechanical properties of weld metal

(Shielding gas :100%CO₂)

	YP (ksi)	TS (ksi)	EL %	IV (ft-lbf)	
				32°F	-320°F
CSF-308L	61.9	82.1	43.0	-	-
CSF-308LP	59.8	82.0	44.0	-	-
CSF-308LP(Cryogenic)	61.2	83.5	42.0	42	28

Size & recommended current range (DC±)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(inch/min.)
1.2(0.045)	150~300	24~33	7.87~23.62
1.6(0.062)	200~400	24~33	7.87~23.62

• **Approval** : CSF-308L : ABS, BV, DNV, KR, LR, NK / CSF-308LP(for cryogenic) : ABS, BV, DNV, LR