

RASI E 308L-T1-1

MADE IN INDIA

FLUX CORED WIRE - AWS E 308L-T1-1

CHARACTERISTICS

RASI E 308L-T1-1 is an extra low carbon Lime Titania all position 19% Cr-10 % Ni stainless steel gas shield flux cored wire. The weld deposit is highly resistance to intergranular corrosion, cracking, oxidation and scaling. It gives uniform and fine rippled bead characterized by excellent all around performance and mechanical properties. Weld metal is of radiographic quality with easy slag removal and low spatters.

WELDING POSITIONS

F, H, V-up and OH

CLASSIFICATIONS

SFA 5.22 AWS: E 308L-T1-1

TYPICAL APPLICATIONS

Used for welding of 18%Cr, 9% Nickel Steel for joining Austenitic Steels such as 304, 304 L, 321, CF-8, CF-3

SHIELDING GAS

Carbon Dioxide (CO₂) shielding
Gas Flow :15-20 Lit / Min
Current Condition : DC (+)

Chemical Composition of Wled Metal (wt %)

	C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
Typical Results	0.040	0.5-2.50	0.010 Max	0.030 Max	0.040 Max	18-21 Max	9.0-11.0	0.50 Max	0.50 Max

All Weld Metal Mechanical Properties :-

	UTS (mpa)	YS (mpa)	Elongation % (L=4xd)	CVN impact at -30C
Typical Results	520 min	---	35 min	---

Welding Parameters (DC + VE)

Diameter	Amps	Volts
1.20 mm	120 - 210	22 - 30
1.60 mm	160 - 250	22 - 30

*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com

*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.