

DESCRIPTION

Executive 308/308L provides superior weldability, low spatter and smooth beads with easy slag removal. Austenitic stainless steel flux cored wire. Due to the lower carbon content in the weld deposit, it is possible to obtain resistance to inter granular corrosion even though used in as-weld condition.

This wire is designed to be used in the flat/horizontal position. Low carbon in this filler metal reduces the possibility of intergranular carbide precipitation. This increases the resistance to intergranular corrosion without the use of stabilizers such as niobium or titanium. Strength of this low-carbon alloy, however, is less than that of the niobium-stabilized alloys or Type 308H at elevated temperatures.

APPLICATIONS & FEATURES

Generally used with 100% CO₂ shielding gas or mixtures of Ar+20~25% CO₂. Used to join 301, 302, and 304 stainless steel. This alloy may also be used for welding types 321 and 347 if the service conditions do not exceed 750F (399C).

This is also available in a thin gauge (TG) **Executive 308/308LTG** in .045" diameter for thin plate welding. It offers wider current ranges (as low as 85 Amps) typically only achieved with costly .035" wire, thus offering a substantial savings.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.02	18.88	9.03	0.08	1.47	0.97	0.02	0.01	0.10

Tensile Strength: 78,900 PSI min
Yield Strength: 61,100 PSI min

Elongation: 42%

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	WFS (in/min)	Shielding Gas*
.045" TG	18-21	85	140	100% CO ₂ or Ar + 20-25% CO ₂
.045" TG	26-29	165	300	
.045" TG	28-34	215	500	
.045"	24	130	225	100% CO ₂ or Ar + 20-25% CO ₂
.045"	27	175	320	
.045"	30	240	530	
.062"	27	195	152	
.062"	31	260	260	100% CO ₂ or Ar + 20-25% CO ₂
.062"	34	320	360	

*Shielding gas flow rate 35 to 50 CFH. For 100% CO₂ use two volts higher than shown

STANDARD PACKAGING

FAW 33-lb plastic spools 1,980-lb pallet

CLASSIFICATION

AWS/SFA 5.22, Class **E308/308LT0-1/4**

