



AWS AWS A5.22 R308LT1-5

JIS Z 3323 TS308L-R1

Characteristics:

LFT-308L is a flux cored wire of stainless steel for TIG welding used on first layer for butt joint. It provides good bead soundness and does not need back shielding. These wires can also be used on multi-layers welding. It is designed with lower range carbon to help prevent inter granular corrosion. It suitable for welding of low carbon 18%Cr-8%Ni stainless steel such as AISI301, 302, 304L, 308L. It is also used for joining some dissimilar 300 series stainless steel.

Notes on Usage:

1. For TIG process, use DC(-) current ,100%Ar shielding gas is recommended.
2. In order to have beautiful back bead appearance, the key hole formation during welding is necessary. The proper key hole size is recommended.
3. High pitch and little by little feeding of a filler rod is a must in order to melt it adequately.
4. 4. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%)

C	Cr	Ni	Mn	Si
0.02	20.20	10.30	1.40	0.4

Sizes and recommended current range (DC -)

Plate Thickness (mm)	Root Gap (mm)	Current (A)
2-4	2.0	80-90
5-9	2.5	90-105
> 10	3.0	90-110