



KISWEL

KISWEL K-308LF

Classifications:

EN ISO 17633-A: T 19 9 L P C(M) 3
EN ISO 17633-B: TS308L-FB0
AWS A5.22-07: E308LT0-1/4

KS D 3612: YF-308LC
JIS Z 3323: TS308L-FB0

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	Ni	Mo
<0.04	<1.00	0.50 – 2.50	18.00 – 21.00	9.00 – 11.00	<0.50

Description:

- K-308LF is designed for FCAW welding of low carbon 18%Cr-8%Ni stainless steel and used to join 301,302, 304 and 308 Stainless Steel.
- It is formulated for operation primarily in the flat position and for welding horizontal fillet welds.
- It has self-detaching slag and spray-like arc transfer and provides low spatter and fume with high efficiency weld deposits in flat position as well as horizontal.
- The weld metal contains optimum ferrite contents in their austenitic structures, therefore their weldability is excellent with lower crack susceptibility.

Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 320	Min. 520	min. 35	60 (-40°C)

Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
1.20 mm	CO ₂	130	280	22	30



ENAR WELD BRAZE PVT. LTD, Enar Chambers, A-112, DDA INDUSTRIAL SHEDS, OKHLA INDUSTRIAL AREA, PHASE - II, NEW DELHI – 110020 ☎ : 011-26383911 /12 /13 Fax : 011-26383913 e-mail : info@enarweld.com

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