



## ENAR WELD BRAZE PVT. LTD

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### KISWEL K-308LF

#### Classifications:

EN ISO 17633-A: 2008: T 19 9 L R C/M 4  
EN ISO 17633-B: 2008: TS308L-FB4  
AWS A5.22-07: E308LT0-1/4

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

#### Typical Chemistry Composition of Weld Deposit:

Shielding Gas	C	Si	Mn	Cr	Ni
CO <sub>2</sub>	<0.04	<1.00	0.50 – 2.50	18.00 – 21.00	9.00 – 11.00

#### Description:

- K-308LF is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to joint 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 It provides low spatter and fume, high efficient weld 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 (%)
min. 390	Min. 520	min. 35