

CSF-308HP

For 18%Cr-8%Ni Stainless steel

AWS	A5.22	E308HT1-1/-4
KS	D 3612	YF308C
JIS	Z3323	TS308H-FB1

Applications

CSF-308HP is suitable for Welding of High carbon 18%Cr-8%Ni Stainless steel.

Characteristics

- (1) CSF-308HP is flux cored wire and designed for Fillet & H-F(All-position) welding with CO₂ gas Shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) Is containing Ferrite of a reasonable quantity and crack-resistance, intergranular corrosion resistance, mechanical properties of weld metal is superior.
- (4) Shield gas is 100%CO₂ or Ar+CO₂ gas.

Notes on usage

- (1) The optimum flow of CO₂ for Shielding is 20~25 ℓ/min.
- (2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO₂)

C	Mn	Si	P	S	Cr	Ni	F/N
0.06	1.04	0.60	0.02	0.007	19.5	10.00	6

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)
			0℃
401	574	40.2	61.0

Size & recommended current range (AC or DC±)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm/min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60