CSF-308MoP

For 18%Cr-8%Ni-2%Mo Stainless steel

AWS A5.22 E308MoT1-1/-4
JIS Z3323 TS308Mo-FB1

Applications

CSF-308MoP is suitable for Welding of 18%Cr-8%Ni-2%Mo Stainless steel.

Characteristics

(1) CSF-308MoP is flux cored wire and designed for Fillet & H-F(All-position) welding with CO_2 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, integranular corrosion resistance, mechanical properties of weld metal is superior.
(4) Shield gas is 100%CO_2 or Ar+CO_2 gas.

Notes on usage

(1) The optimum flow of CO_2 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%CO_2)

C	Mn	Si	P	S	Cr	Ni	Mo	F/N
0.03	1.00	0.60	0.03	0.02	19.6	10.0	2.5	20

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO_2)

YP N/mm²(MPa)	TS N/mm²(MPa)	EL %
495	673	35.0

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