

SW-308LT

TYPE : Rutile

AWS A5.22 / ASME SFA5.22 E308LT1-1/-4
JIS Z3323 TS308L-FB1
EN ISO 17633-A-T 19 9 L P M/C 2

Applications

SW-308LT is designed for welding of extra-low carbon 18%Cr-8%Ni stainless steel for cryogenic applications.

Characteristics on Usage

SW-308LT is a titania type flux cored wire for all position welding with CO₂ & Argon+CO₂ mixed shielding gas. This wire is designed for cryogenic applications, 304L austenitic stainless steels.

The high impact toughness at cryogenic temperature (-196°C) makes SW-308LT excellent in LNG applications.

Arc stability is excellent, so spatter loss is low and slag covering is uniform with good removability.

Notes on Usage

- ① Both 100% CO₂ and mixed (Ar+20~25% CO₂) gas are useful.
- ② Welders for solid wire can be used but as wire is softer than solid wire, pay full attention to adjust feeding roller and do not tighten them excessively.
- ③ Use the wind-screen against wind.
- ④ Where possible, preferred storage conditions of opened packs are 60% RH maximum, 18 minimum.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

CO₂/Ar+20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%) (Shielding Gas: 100% CO₂)

C	Si	Mn	P	S	Cr	Ni
0.034	0.59	1.52	0.023	0.013	19.2	10.1

Typical Mechanical Properties of All-Weld Metal (Shielding Gas: 100% CO₂)

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
402 (58,300)	550 (79,800)	49.8	-196 (-321)	35 (26)

Approval

I Packing(Including Ball Pac)

ABS	Dia. (mm)	1.2	Spool(kg)	15
	(in)	.045		(lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	180 ~ 220
V-up, OH	120 ~ 160