SW-308LT

Type : Rutile

Conformances

AWS A5.22/ ASME SFA5.22 E308LT1-1/-4

JIS Z3323 TS308L-FB1

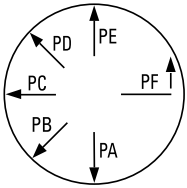
EN ISO 17633-A-T 19 9 L P M21/C1 2

ABS AWS A5.22 E308LT1-1
(-196°C ≥27 J)

Applications

- Cryogenic service such as LNG storage tank
- 18% Cr-8%Ni stainless steels

Welding Position



Features

- Good impact value at cryogenic temperatures
- Good performance in all positions

Current

DC +

Shielding Gas

100% CO_2

Ar + 20~25% CO_2

Diameter / Packaging

Diameter	Spool			Pac		
mm (in)	5kg (11lbs)	12.5kg (27.6lbs)	15kg (33lbs)	250kg (551lbs)	300kg (661lbs)	350kg (771lbs)
1.2 (0.045)	√	√	√			

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO_2	0.019	0.76	1.52	0.015	0.010	10.66	18.40	0.02
80% Ar + 20% CO_2	0.019	0.76	1.52	0.015	0.010	9.66	18.40	0.02

Typical Mechanical Properties of All-Weld Metal

	TS MPa(lbs/in^2)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
100% CO_2	567 (82,215)	48.4	-196 (-321)	34 (25.1)
80% Ar + 20% CO_2	573 (83,085)	48.4	-196 (-321)	36 (25.6)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO_2	20 (4/5)	6.2 (244)	140	23~26	2.6 (5.7)
		9.2 (362)	180	27~30	3.5 (7.7)
		12.2 (480)	210	28~31	4.8 (10.6)
80% Ar + 20% CO_2	20 (4/5)	6.2 (244)	140	23~26	2.6 (5.7)
		9.0 (354)	180	27~30	3.6 (7.9)
		12.0 (472)	210	27~30	4.9 (10.8)