

Exaton 308/308L T1

FCAW wire for 18%Cr - 8%Ni stainless steel, For all-position welding. For welding types 301, 302, 304, 304L, 308 and 308L of stainless steel. May be used for welding types 321 and 347 if service temperature does not exceed 500°F(260°C). Low carbon content minimizes carbide precipitation. Ferrite values will lower as impact toughness increases. Carbon content 0.04% maximum.

Specifications

Classifications

SFA/AWS A5.22 : E308LT1-1
 SFA/AWS A5.22 : E308LT1-4
 JIS Z 3323 : YF 308LC
 KS D 3612 : YF 308LC
 EN ISO 17633-A : T 19 9 L P C1 2
 EN ISO 17633-A : T 19 9 L P M21 2

Welding Current

DC+

Alloy Type

C Cr Ni

Shielding Gas

M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 Shielding Gas			
As Welded	410 MPa (59 ksi)	580 MPa (84 ksi)	44 %
C1 Shielding gas			
As Welded	372 MPa (54 ksi)	568 MPa (82 ksi)	61 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding gas		
As Welded	-29 °C (-20 °F)	60 J (44 ft-lb)
As Welded	-196 °C (-321 °F)	30 J (22 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr
M21 Shielding Gas						
0.030	1.20	0.90	0.007	0.025	10.1	19.3
C1 shielding gas						
0.025	1.10	0.70	0.007	0.025	10.0	19.1

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (0.045 in.)	130-220 A	24-29 V	5.8-14.4 m/min (228-567 in./min)	1.9-4.6 kg/h (4.2-10. lbs/h)