

# TOKO E308LT1-1

Classifications:  
AWS A5.22 E308LT1-1  
EN T 199 LP C1  
ISO 17633 B-TS308L-FC1

Flux Cored Wire for Stainless Steel

## Characteristics and Applications:

TOKO-308L is a rutile flux cored tubular wire for all positional welding using pure CO<sub>2</sub> shielding gas. It performs with smooth arc transfer, self-releasing slag, low spatter level, fine ripple and good intergranular corrosion resistance. 308L is suitable for welding 18%Cr-8%Ni stainless steels. Its typical applications include corrosion resistance overlay, joining of common austenitic stainless steel types 301, 302, 304, 304L, stabilised 321, CF-8 and CF-3.

Welding Position: 

## Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
AWS	0.04	0.5-2.5	1.0	18.0-21.0	9.0-11.0	0.5	0.04	0.03	0.5
EX	0.028	1.41	0.46	19.87	9.75	0.16	0.012	0.011	0.21

## Typical Mechanical Properties of Weld Metal:

Mechanica properties	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation%	Impact Value (J/°C)
AWS	—	520	35	—
EX	—	577	46	—

## Notes on Usage:

1. Electric current : DC+
2. Clean up water, rust, oil on the base metal to avoid porosity and crack..
3. Shielding Gas:100%CO<sub>2</sub> with gas flow rate of 20~25L/min and ESO of 15~20mm
4. Preheat by 150 ± 15°C for base metal;
5. Proper heat input to obtain required impact value

## Sizes Available and Recommended Parameters:

Dia/mm	F, H		V UP		OV	
	A	V	A	V	A	V
1.2	140-220	23-33	120-180	24-28	160-200	26-30
1.6	200-300	27-32	—	—	—	—