

DATA SHEET No. S007

DAIKO FCW 308L

Flux Cored Wire

Description / Alloy type: Flux cored wire for 304L stainless steel base materials.

Specifications: **AWS A5.22**
E308LT0-1/4

Applications: These consumables are used to weld 18/8 stainless steels.
Mainly applications include food industries, pharmaceutical equipment and general fabrication.
Typical service temperatures are -100°C to 400°C.

Composition:
(weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Typ	0.03	1.3	0.7	<0.02	<0.02	19.5	10	0.1	0.1

FN (WRC-92) = 6-10

Typical parameters:

d. 1,20mm

Shielding	80%Ar-20%CO ₂
Polarity	DC+
Current	120 - 280 A
Voltage	21 - 35 V
Stick-out	12-25mm

All-weld proprieties:

As welded	min	Typical
Tensile strength [MPa]	520	560
Yield strength [MPa]	320	400
Elongation 5d [%]	30	40
Impact Energy -20°C [J]	-	>50

Welding positions:



PA, PB (EN ISO)
1F, 1G, 2F (ASME)

Other products:

G-Tech 308L SMAW electrode (AWS A5.4 E308L-15/16/17)
Daiko SF 308L MIG, TIG & SAW wire (AWS A5.9 ER308L)
Daiko SF 308LSi MIG & TIG wire (AWS A5.9 ER308LSi)
Daiko FCW 308LP FCAW wire (AWS A5.22 E308LT1-1/4)
ESW strip (A5.9 EQ308L)