CSF-308HP

For 18%Cr-8%Ni Stainless steel

AWS	A5.22	E308HT1-1/-4
KS	D 3612	YF308C
JIS	Z3323	TS308H-FB1

Applications

CSF-308HP is suitable for Welding of High carbon 18%Cr-8%Ni Stainless steel.

Characteristics

(1) CSF-308HP is flux cored wire and designed for Fillet & H-F(All-position) welding with CO_2 gas Shielding.
(2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
(3) Is containing Ferrite of a reasonable quantity and crack-resistance, integranular corrosion resistance, mechanical properties of weld metal is superior.
(4) Shield gas is 100%CO_2 or Ar+CO_2 gas.

Notes on usage

(1) The optimum flow of CO_2 for Shielding is 20~25ℓ/min.
(2) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
(3) Keep the distance between tip & base metal at 15~25mm.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO_2)

C	Mn	Si	P	S	Cr	Ni	F/N
0.06	1.04	0.60	0.02	0.007	19.5	10.00	6

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO_2)

YP N/mm²(MPa)	TS N/mm²(MPa)	EL %	IV (J) 0℃
401	574	40.2	61.0

Size & recommended current range (AC or DC±)

Dia. mm (in)	Current(A)	Voltage(V)	Welding Speed(cm/min)
1.2(0.045)	150~300	24~33	20~60
1.6(0.062)	200~400	24~33	20~60