

# HANKOOK WELDTEK CO.,LTD

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## WT-308LP

AWS A5.22 E308LT1-1/4

JIS Z3313 YF308LC

KS D3612 YF308LC

FOR STAINLESS  
STEEL

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### Applications

WT-308LP is designed for MAG welding of low carbon 18%Cr-8%Ni stainless steels. (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D)

### Characteristics on Usage

- 1) This is a rutile type flux cored wire for all-position welding.
- 2) Excellent weldability and increased creep resistance at elevated temperature.
- 3) The weld metal contains optimum ferrite contents in their austenitic structures  
Therefore their weldability is excellent with lower crack susceptibility.

### Notes on Usage

- 1) Use 100% CO<sub>2</sub> gas or Ar+20~25% CO<sub>2</sub> gas.
- 2) The optimum flow of CO<sub>2</sub> for shielding is 20~25ℓ/min.
- 3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- 4) Keep the distance between tip & base metal at 15~25mm.
- 5) For multi layer welding, keep preheat and inter-pass temperature below 150°C.

**Typical chemical composition of all-weld-metal (%)**(Shielding gas : CO<sub>2</sub>)

	chemical composition(%)							
	C	Si	Mn	P	S	Cr	Ni	Mo
AWS	≤0.04	≤1.0	0.5~2.5	≤0.04	≤0.03	18~21	9~11	≤0.5
WT-308LP	0.02	0.7	1.28	0.022	0.004	18.9	9.9	0.01

**Typical mechanical properties of all-weld-metal** (Shielding gas : CO<sub>2</sub>)

	Tensile strength (N/mm <sup>2</sup> )	Elongation %	Impact value (J)	
			0°C	-18°C
AWS	≥ 520	≥ 35	-	-
WT-308LP	572	43	-	54

**Size available and recommend welding parameters (DC+)**

Position		Dia	1.2(.045)	1.6(1/16)
			Current(A)	Current(A)
Flat	Current(A)		180~220	200~280
Horizontal Fillet			180~220	200~280
Vertical up			120~160	160~220

**Welding positions**



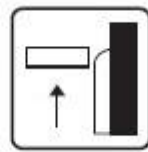
1G



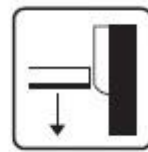
2F



3G



V-UP



V-DOWN



4G