

CHT308L

Flux-Cored Wire for High Tensile Steel

AWS A5.22 E308LT1-1
ISO 17633-A-T 19 9 L P C1 1
ASME SFA-5.22 E308LT1-1
NB/T 47018.1 E308LT1-1

Type of Flux: Rutil

Welding Position: F, H, HF, OH, V

Type of Current: DC

Features & Applications

CHT308L(E308LT1-1) is a non-metallic powder stainless steel flux-cored wire and it is the most widely used austenitic stainless steel welding material. The welding performance is very good with less spatter and stable arc. The weld forming is beautiful and the wire feeding is smooth. It is suitable for all-position welding. The weld is with good heat resistance and corrosion resistance.

CHT308L(E308LT1-1) is suitable for welding 022Cr19Ni10 steel, and is mostly used in petrochemical industry, pressure vessels, medical equipment, food equipment, fertilizers and other fields.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Standard	≤0.04	0.5~2.5	≤1.00	≤0.03	≤0.04	18.0~21.0	9.0~11.0	≤0.75	≤0.75
Atlantic	0.030	1.74	0.60	0.003	0.016	19.29	9.34	0.034	0.08

Mechanical Properties of Deposited Metal:

	Yield Strength ReH (MPa)	Tensile Strength Rm (MPa)	Elongation A4 (%)	Impact Value (J)		Shield Gas
				-20	-30	CO ₂
Standard	—	≥520	≥25	—	—	purity≥99.98%
Atlantic	—	565	42	55	—	

The standard of mechanical properties conforms to shipping institutions and the certificate of inspection would follow it unless the purchaser has special requirement.

X-ray radiographic inspection: Grade II

Recommended Current (DC)

Diameter(mm)		1.2	1.6
Current (A)	F	160-240	180-270
	HF	160-240	180-270
	OH	120-180	140-200
	H	160-220	180-270
	V	120-180	140-200

Approvals

Institute	CCS	LR	ABS	BV	DNV*GL	NK	TUV
Grade	304LS	304LS	E308LT1-1	308L	NV308L	KW308LG(C)	CE

Notice: 1) The flow rate of shield gas (CO₂) should be within 20L-25L/min during welding.

2) The wire extension should be 15mm-25mm.

3) The surfaces to be welded must be cleaned away impurities of oil contamination, rusted layer, dust, etc.

4) The purity of CO₂ gas must be more than 99.95% when adopting CO₂ gas shield.

5) For outdoor welding, when the wind speed is greater than 1.5m/s, we should take precautions against the wind, there must be appropriate windproof facilities to avoid porosity.