

CODIFICATION: AWS/SFA 5.22

E308LT1-1

CHARACTERISTICS AND APPLICATIONS:

Maxfil-308L is an all position stainless steel flux cored wire designed for optimum performance with 100% CO₂ gas shielding. This wire is designed with fast freezing slag characteristics and good slag detachability. The wire welds satisfactorily in out of position and performs equally well when welding in the flat & horizontal position. The weld metal is of radiographic quality, resistant to cracking, and very good oxidation & scaling resistant at elevated temperature.

Maxfil-308L is designed for welding of low carbon similar composition steels like AISI 304/ 304L and their equivalents with excellent weld ability.

CHEMICAL COMPOSITION OF ALL WELD METAL (%):

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Range	0.040	0.5-2.5	1.00	0.030	0.040	18.0-21.0	9.0-11.0	0.75	0.75
Typical	0.025	1.32	0.60	0.010	0.015	19.5	9.5	0.010	0.030

MECHANICAL PROPERTIES OF ALL WELD METAL:

Property	UTS (MPa)	% El (L=4d)
Range	520 Min	30 Min
As Welded	540	38

WELDING POSITIONS: H, F, VU, OH

WELDING PARAMETER: DC (+)

Diameter (mm)	HORIZONTAL/FLAT		VERTICAL UP		OVERHEAD	
	Volt, V	Current, A	Volt, V	Current, A	Volt, V	Current, A
1.20	24-30	160-260	20-22	100-160	22-25	100-160
1.60	24-30	180-300	20-22	110-200	22-25	110-200

SHIELDING GAS:

➤ Carbon Dioxide CO₂ (100%) at flow rate 12-15 litres per minute.

PACKING:

Standard size : 1.20 & 1.60mm.

Quantity : Supplied approximately 12.5/15Kgs in a plastic spool. Each spool is sealed in an air tight polythene bag and then packed in a corrugated box.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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