



In-Flux[®] 308L-O

AWS A5.22 E308LT0-3

Original

180-A Index : 100217

DESCRIPTION:

An austenitic stainless steel with low carbon used for joining common austenitic stainless steels such as Types 304, 304L, 321, CF-8, and CF-3. It provides good resistance to intergranular corrosion. It can be used as an intermediate layer for hard surfacing.

SHIELDING GAS: None

TYPICAL WELD METAL CHEMISTRY*(Chem Pad):

Weld Metal Analysis

	308L-O	AWS Spec.
Carbon (C)	0.02	0.03 max
Manganese ((Mn)	1.10	0.5-2.5
Silicon (Si)	0.44	1.0 max
Chromium (Cr)	20.20	19.5-22.0
Nickel (Ni)	9.80	9.0-11.0
Molybdenum (Mo)	0.008	0.70 max
Iron (Fe)	Bal.	Bal.

TYPICAL WELD METAL PROPERTIES* (AS WELDED):

Tensile Strength	94,000 psi
Yield Strength	70,000 psi
Elongation % in 2"	40%
DeLong Ferrite Number	8

CONFORMANCES AND APPROVALS:

- AWS A5.22 • ASME SFA5.22

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and McKay expressly disclaims any liability incurred from any reliance thereon. Typical data are obtained when welded and tested in accordance with AWS A5.22 specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by McKay.



In-Flux 308L-O

AWS A5.22 E308LT0-3

WELDING DATA:

The information listed below was determined by welding performed with DCEP welding current.

Parameters

Diameter	Volts	Amps	Wire Stick-Out	Dep. Rate (lbs./hour)	Optimum Parameters	
					175 amps	26 volts
1/16"	26-32	150-275	1/2"-1"	9-15	175 amps	26 volts
3/32"	26-30	225-350	1"-1 1/2"	13-17	275 amps	26 volts

AVAILABLE DIAMETERS AND PACKAGES

Diameter		25-lb.	60-lb.
1/16"	1.6	S670919-029	S670919-062
3/32"	2.4	--	S670929-062

CAUTION:

Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standard Z49.1, "Safety in Welding and Cutting," published by the American Welding Society, 550 NW Le-June Road, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

McKay Safety Data Sheets on any McKay product may be obtained from McKay Customer Service.

Because McKay is constantly improving products, McKay reserves the right to change design and/or specifications without notice.