

HTS-308L

Austenite/Mixed gas

Conform to GB/T 17853 TS 308L-F M21

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Equal with AWS A5.22 E308LT1-4

A5.22M E308LT1-4

EN ISO 17633-A:T 19 9 L P M21 1

EN ISO 17633-B:TS 308L-F M21 1

Description: The weld metal contains an appropriate amount of ferrite and has low crack sensitivity. Excellent welding performance, stable arc, less spatter, good deslagging, show excellent welding performance.

Application: Suitable for petrochemical, pressure vessel, food machinery, medical machinery, textile machinery and other related industries, welding 18%Cr-8%Ni stainless steel (SUS304, 304L).

Chemical composition of deposited metal (Mass fraction)

Alloy	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
GB	0.04	0.5-2.5	1.0	18.0-21.0	9.0-11.0	0.50	0.04	0.03	0.50
AWS	0.04	0.5-2.5	1.0	18.0-21.0	9.0-11.0	0.75	0.04	0.03	0.75

Mechanical properties of deposited metal: (Heart treatment 605°CX1h)

Mechanical property	Yield/MPa	Tensile/MPa	Elongation%	Impact J/°C
GB	-	≥520	≥35	-
AWS	-	≥520	≥30	-

Recommended welding parameters (DC⁺) (All-position welding)

Size/mm	1.2	1.6
Voltage V	20-34	26-38
Current A	120-260	200-300
Dry extension/mm	15-20	18-25
Gas flow l/min	15-25	15-25

Notice:

- 1.Rust, oil, water and other impurities must be removed from the weldment before welding;
- 2.Shielding gas: 75-80%Ar+CO₂;
- 3.Pre-heat and Interpass temp: 16-100°C;
- 4.When welding in a windy place, windproof measures should be taken to avoid the generation of pores when the wind is strong.