

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GF308L

Applicable Specification

JIS Z 3323 TS308L-FB0
AWS A5.22 E308LT0-1/4

● Applications and Characteristics

TASETO GF308L is used for welding of Type 304 and 304L stainless steel. Because of low carbon content, the resistibility to intergranular corrosion is excellent and suitable for use in the case where solution heat treatment is impracticable.

● Notes on Usage

* Please refer "Guideline for Welding Stainless Steel with GF3 Wires".

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.026	0.39	1.55	0.018	0.003	10.19	19.86	0.02	0.02

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 8.3% (Schaeffler's Diagram)
11.4FN (DeLong's Diagram)
9.0% (Ferrite Scope)

● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	5D Elongation (%)	Absorbed Energy (J at -196°C)
Typical	352	543	44.0	32

● Corrosion Resistance of All Weld Metal

* Typical Corrosion Resistance 0.00076 in/month (0.22 g/m²·h)
(65% Nitric Acid Test)
180° bend without any defects
(Copper Sulfate-Sulfuric Acid Test : PWHT650°C × 2h)

● Sizes Available, Shielding Gas

Size (mm)	Shielding Gas
1.2	CO ₂ or Ar+20%CO ₂ , 20L/min
1.6	CO ₂ or Ar+20%CO ₂ , 20L/min