

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

GFW308L3

Applicable Specification

JIS Z 3323 TS308L-FB0

AWS A5.22 E308LT0-1/4

● Applications and Characteristics

TASETO GFW308L3 is used for welding of Type 304 and 304L stainless steel, same as GFW308L. As the carbon content is further decreased to 0.030% or less, the resistibility to intergranular corrosion is better than that of GFW308L.

● Notes on Usage

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

● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Typical	0.018	0.53	1.37	0.016	0.004	9.73	19.10	0.02	0.02

● Ferrite Content of All Weld Metal

* Typical Ferrite Content: 9.0% (Schaeffler's Diagram)
11.6FN (DeLong's Diagram)
10% (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	384	585	39.0	35

● Corrosion Resistance of All Weld Metal

* Typical Corrosion Resistance 0.00073 in/month (0.21 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