

Stainless Steel Flux Cored Wire

GMX308LF

AWS A5.22 E308LT0-1/4
ISO 17633-A-T 19 9 L P C1 3, M21 3

Product Features:

- GMX308LF is especially developed for flat and high deposition welding. The smooth weld metal transfer and easy slag removal eliminates unnecessary clean up. The weld bead is uniform, flat to slightly concave and free from porosity.
- Penetration is complete and easy to obtain the flat equal weld leg.
- For welding types of 301, 302, 304, 304L, 305, 308L steel. The content of lower carbon helps minimize carbide precipitation and obtain more resistance to inter-granular corrosion.

Guideline in Usage :

- Use general CO₂ welding machine, but loosen the wire-feeding roller.
- This wire is formulated for using 75% Argon plus 25% CO₂ gas shielded or straight CO₂ gas. However, the 75%Ar / 25%CO₂ mixture gas will produce a smoother arc with less spatter and slight higher yield and tensile strength.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Ni	Mo	S	P
0.03	0.6	1.5	19.8	10	0.03	0.012	0.017

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
390	565	41

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DCRP	DCRP
Ampere (A)	Flat position	160~250	220~300
	Vertical up position	-	-
Voltage	Flat position	22~32	24~30
	Vertical up position	-	-
Shielding Gas		CO ₂ / Mixed Gas	CO ₂ / Mixed Gas

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw