

# Stainless Steel Flux Cored Wire

## GMX308L

AWS A5.22 E308LT1-1/4  
A5.22M E308LT1-1/4  
JIS Z 3323 TS308L-FB1  
ISO 17633-A-T 19 9 L P C1 1, M21 1

### Product Features:

- Rutile type gas shield flux cored arc welding wire, austenite structure weld metal.
- Smooth arc, low spatter loss and easy slag removal.
- Low carbon content in weld metal to get good crack and inter-granular corrosion resistance.
- Good bead appearance.
- Easy to get Smooth fillet weld size.

### Applications:

- Suitable for welding of stainless steels such as SUS301, 302, 304, 304L and 305.

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

C	Si	Mn	Ni	Cr	Mo	Fe
0.02	0.44	1.62	9.68	18.79	0.07	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-20°C) J
414	586	40	79

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat / Horizontal position	150~250	200~300
	Vertical / overhead position	100~140	----
Shielding Gas		CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub>	CO <sub>2</sub> /80%Ar+20%CO <sub>2</sub>

### Note:

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