

SUPERCORE 308LP



Supercore 308LP is recommended for welding 18/8 stainless steels including 301, 302, 303, nitrogen bearing 304LN and titanium stabilised 321. Service temperatures are typically – 100°C to about 400°C, although solid wires and Ultramet 308LCF are suitable for service down to –196°C. Applications include food, brewery, pharmaceutical equipment, architectural and general fabrication, and nuclear engineering.

SPECIFICATIONS

AWS	A5.22	E308LT1-4
BS EN	12073	T 199 L P M 2

CHEMICAL ANALYSIS

% Carbon	0.030	% Chromium	19.50
% Manganese	1.300	% Nickel	10.00
% Silicon	0.700	% Molybdenum	0.100
% Sulphur	0.020	% Copper	0.100
% Phosphorous	0.020	% Ferrite	8

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	560 MPa
0.2% Proof Stress	400 MPa
Elongation on 4d	43%
Impact Energy 20°C	80 J
Impact Energy -110°C	40 J

Microstructure

Austenite with a controlled level of ferrite, normally in the range 2-10FN depending on the application.

PACKING DATA

(DC+)

Diameter (mm)	Current (A)		Stickout (mm)	Item Number	Pack Mass (Kg)
	Amps	Volts			
1.20	120 - 250	20 - 32	15 - 20	081-100	15

Suggested gas for FCW welding: Fluxshield

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