FILOTECH
Electrodes inc.

E - 3 0 8 - T - X

Characteristics

- open arc flux-cored welding wire;
- **austenitic heat-resisting steel**;
- often used to weld alloys of similar composition (300 class);
- **resists corrosion, erosion, and oxidation**;
- used in applications requiring moderate heat resistance;
- in addition to **improved weldability** as compared to solid wires, flux-cored 308 is always **consistent** in its **metallurgy**;
- costly gas shielding and/or cumbersome fluxing agents are **not required**;
- fluxes within the wire provide the necessary shielding agents to protect the weld deposit from contamination;
- **easily removable slag** reveals a smooth slightly convex bead of shiny stainless steel;
- conforms to AWS 5.22

Mechanical Properties

- Yield: 55,000 psi. min.
- Tensile: 70,000 psi. min.
- Elongation in 2": 35% min.

Procedures

- DC reversed polarity, 28-30 Volts, 300-400 Amps.
- remove all damaged materials on surface to be welded
- preheat to 600°F
- avoid thermal shock
- stick-out: 2 - 3"

Other

- deposition rate: 10 - 20 lbs./hr.
- available in 7/64", 3/32" and 5/64" diameter
- packaging: 28 lb. plastic spools, 55 lbs. coils, 100 & 250 lb. pay-off-packs

ENREGISTRÉ BNQ ISO 9002 REGISTERED

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