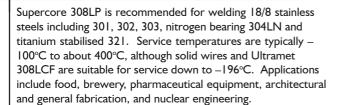
PRODUCT DATA SHEET

SUPERCORE 308LP





SPECIFICATIONS

AWS	A5.22	E308LT1-4	
BS EN	12073	T 199LPM2	

CHEMICAL ANALYSIS

% Carbon	0.030	
% Manganese	1.300	
% Silicon	0.700	
% Sulphur	0.020	
% Phosphorous	0.020	

% Chromium	19.50	
% Nickel	10.00	
% Molybdenum	0.100	
% Copper	0.100	
% 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 - I 10°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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