

# ES FC 308LT

Type Rutile

FCAW

E308LT1-4

**ESWECO**  
*The Art of Welding*

## Description

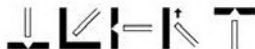
ES FC 308LT is a rutile, flux-cored wire, specifically designed to operate in the vertical and overhead positions when welding 304, 304L, 308 and 308L stainless steels. The stabilised 321 and 347 steels may also be welded.

Typical application: welding 304L and other common 18/8 stainless steels, Nitrogen bearing 304LN and titanium stabilized 321 and General fabrication including piping, tanks, and pressure vessels

Shielding gas  
Ar+20%CO<sub>2</sub>.

## Current

DC+



## Classifications

EN 12073	T 19 9 L P M 2
SFA/AWS A5.22	E308LT1-4

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni
0.032	0.8	1.2	19.5	10.0

## Typical mech. Properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	593
Elongation, %	45

## Welding parameters

Diameter, mm

1.2

Welding current, A

130-230

Arc voltage, V

26-31