

AK E308LT0-3

Description: AK-E308LT0-3 is a shelf-shielded, flux core, stainless steel wire designed to weld in the flat and horizontal positions. It has a nominal weld metal composition of 21% chromium and 10% nickel, with a maximum content of 0.03%. The low carbon minimizes carbide precipitation and makes the weld metal more resistant to intergranular corrosion.

Application: AK-E308LT0-3 is used for the cladding of carbon steels. It may also be used to weld 301, 302, 304L, 308, and 308L stainless steel.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Requirement	0.04	1.00	0.50-2.50	0.03	0.04	9.0-11.0	18.0-21.0	0.75	0.75
Actual Result	0.035	0.48	1.13	0.018	0.028	9.18	18.25	0.02	0.018

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥ 520	---	≥ 30	---
Actual Result	543	---	35	---

Recommended welding parameters:

Diameter/ mm	1.2	1.6		
Welding voltage/V	22-36	26-38	---	---
Welding current/A	120-260	200-300	---	---