

# SF-30<sub>x</sub>SW-308/308L

AWS A5.39 ER308/308L  
EN ISO 14343-A S 19 9 L  
GB -

## SUBERED ARC WELDING WIRE AND FLUX FOR STAINLESS STEEL

### DESCRIPTION & APPLICATIONS :

- SW-308L is low carbon 18%Cr-8%Ni, designed for welding SUS304 grade stainless steel.
- With appropriate contents of ferrite in weld metal, due to that the characteristic of great crack and corrosion resistibility, excellent slag removal and smooth bead appearance.

### NOTE ON USAGE :

- SF-30 is an agglomerated flux. Rebake flux at 350°C for 1hour after opening use.
- Appropriate new flux is required to add with the recycling used flux to maintain welding quality.

### TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P
0.02	1.58	0.60	0.017
S	Ni		Cr
0.009	9.60		19.60

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	
570(58.2)	
ELONGATION RATE %	IMPACT VALUES -196°C J(Kgf-m)
40	33(3.4)

# SF-30<sub>x</sub>SW-309/309L

AWS A5.39 ER309/309L  
EN ISO 14343-A S 23 12 L  
GB -

## SUBERED ARC WELDING WIRE AND FLUX FOR STAINLESS STEEL

### DESCRIPTION & APPLICATIONS :

- SW-309L is low carbon 22%Cr-12%Ni, designed for welding SUS309S grade stainless steel and groove root passing.
- With high contents of ferrite in weld metal.

### NOTE ON USAGE :

- SF-30 is an agglomerated flux. Rebake flux at 350°C for 1hour after opening use.
- Appropriate new flux is required to add with the recycling used flux to maintain welding quality.

### TYPICAL CHEMICAL COMPOSITION OF WELD METAL :

C	Mn	Si	P
0.02	1.48	0.62	0.021
S	Ni		Cr
0.010	13.32		23.25

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

TENSILE STRENGTH N/mm <sup>2</sup> (Kgf/mm <sup>2</sup> )	ELONGATION RATE %
567(57.9)	41