Superflux 300S X YS-308L [YS-309L, YS-316L]

Type : Neutral

Conformances

JIS Z3352 SA AB2
EN ISO 14174-S A AB 2
KR RV308L TM, RV316L TM
ABS AWS A5.9 ER316L [Wire]
BV UP (-60°C ≥27 J)

Applications

- 18%Cr-8%Ni stainless steel

Features

- Good resistance to crack and corrosion
- Easy to remove slag
- Good bead appearance
- Density : 1.2g/cm^3

Current

AC, DC +

Basicity Index

1.0

Packages (Flux)

Tin Can 20kg(44lbs)
PE Bag 20kg(44lbs)

Flux Composition

Consumable	Chemical Composition, wt%			
	$SiO_2 + TiO_2$	$Al_2O_3 + MnO$	$MgO + CaO$	CaF_2
Superflux300S	30	20	40	10

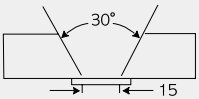
Typical Chemical Composition of All-Weld Metal(%)

Wire	C	Si	Mn	Cr	Ni	Mo
YS-308L	0.03	0.90	1.30	20.3	9.8	
YS-309L	0.03	0.93	1.40	22.5	12.8	
YS-316L	0.03	0.90	1.40	19.2	12.1	2.1

Typical Mechanical Properties of All-Weld Metal

Wire	TS MPa(lbs/in²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
YS-308L	600 (87,000)	42	-196 (-321)	40 (30)
YS-309L	570 (82,700)	38		
YS-316L	550 (79,800)	38	-196 (-321)	40 (30)

Typical Welding Parameters

Wire	Dia. (mm)	Th. (mm)	Groove Design (mm)	Pass	Amp. (A)	Volt. (V)	Speed (cm/min)	Remarks
YS-308L YS-309L YS-316L	4.0	20		1~10	550	32 30	50	JIS Z3324