



## MODI FC 308 LT FOR STAINLESS STEEL

**CLASSIFICATION** : AWS/A 5.22 : E 308L T1-1/-4

**TYPICAL APPLICATIONS** : Modi FC 308LT is suitable for MAG welding of low carbon 18% Cr - 8% Ni stainless steels (AISI 304, 304L, 304 LN, ASTM A157 Gr, C9, A320 Gr, B8C or D)

**CHARACTERISTICS :**

1. Modi FC 308LT is a titania type of flux cored wire for all position welding.
2. Excellent weldability and increased creep resistance at elevated temperature.
3. The weld metal contains optimum ferrite contents in the austenitic structures. Therefore their weldability is excellent with lower crack susceptibility.
4. The shielding gas should be used 100% CO<sub>2</sub> and 80% Ar + 20% CO<sub>2</sub> for welding.

**CHEMICAL ANALYSIS OF WELD-METAL(%) :**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.040	0.5-2.5	1.0	0.03	0.04	18.0-21.0	9.0-11.0	0.5	0.5
max		max	max	max			max	max

**MECHANICAL PROPERTIES OF ALL WELD-METAL :**

Ultimate Tensile Strength (min)	Elongation (%)
N/mm <sup>2</sup> (Kg/mm <sup>2</sup> )	(min)
520(53)	35

**CURRENT CONDITIONS** : Use DC (+)

**SIZE (mm)** : 1.2 1.6

**AMPS** : 100-220 160-260



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