



MODI FC 308T FOR STAINLESS STEEL

CLASSIFICATION : AWS/A 5.22 : E 308T0-1/-4

TYPICAL APPLICATIONS : Modi FC 308T is formulated for MAG welding of 18% Cr - 8% Ni stainless steels. It is designed for operation primarily in the flat position and for welding horizontal fillet welds.

CHARACTERISTICS :

1. Modi FC 308T is a titania type of flux cored wire for AISI 304 type.
2. Wire has low spatter, easy slag removal and good weld soundness.
3. The weld metal contains optimum ferrite contents in their austenitic structures. Therefore their weldability is excellent with lower crack susceptibility.
4. The shielding gas should be used 100% CO₂ and 80% Ar + 20% CO₂ for welding.

CHEMICAL COMPOSITION OF ALL WELD-METAL(%) :

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.080	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 ² (Kg/mm ²)	(min)
550(57)	35

CURRENT CONDITIONS : Use DC (+)

SIZE (mm) : 1.2 1.6

AMPS : 100-120 160-260



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