



FALCON Series
WELDING PERFECTION

FALCON E308LT1

FALCON E308LT1 is a quality rutile based stainless steel flux cored wire designed for all-positions welding with 100% CO₂ shielding. This product suitable for welding 18%Cr-8%Ni materials, typical applications include corrosion resistance overlay, joining common austenitic stainless-steel material such as 301, 302, 304, 304L, stabilised 321, CF-8 and CF-3. Produce smooth bright and flat weld bead with easy slag removal.

Classifications

AWS A5.22	E308LT1-1
ASME SFA-A5.22M	E308LT1-1
EN ISO 17633-A:	T199 L P C1 1
EN ISO 17633-B:	TS 308L-F C1 1

Typical all weld metal composition, wt. %

	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
AWS	≤0.04	0.5-2.5	≤1.0	18.0-21.0	9.0-12.0	0.75	0.040	0.030	0.75
Typical	0.021	1.08	0.43	19.49	9.65	0.01	0.024	0.003	0.03

Mechanical properties of all well metal

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V (J/°C)
AWS	as welded	-	520	30	-
Typical	as welded	-	550	40	-

Operating Parameters

Polarity	Shielding	Current (A)	Voltage (V)	Gas flow
DCEP	100% CO ₂	120-260 (1.2mm)	22-36 (1.2mm)	20-25 L/min (1.2mm)
		200-300 (1.6mm)	25-38 (1.6mm)	20-25 L/min (1.6mm)

Packing & Ordering Information

Wire sizes	Carton Weight	Pallet Weight	Packing method
1.2mm 1.6mm	12.5kg	1,050kg	Vacuum packed

- Proper wind-shielding measures are advisable to avoid porosity.
- Control inter-pass temperature within 16-100°C.
- Ensure base materials are free from moisture, dust, rust, and oil before welding.

A Quality Product of

