



Shield-Bright 308L Xtra

FCAW

Shield-Bright 308L Xtra is designed primarily for welding types 301, 302, 304, 304L, 308 and 308L types of steels in the flat and horizontal positions. May be used for welding types 321 and 347 if service temperature does not exceed 260°C. Low carbon content minimises carbide precipitation. Weld beads are finely rippled and horizontal fillets have an essentially flat surface and equal leg length. Either pure CO₂ or mixed gas (75% Argon/25% CO₂) can be used.

Welding Current

DC (+)

Shielding Gas

CO₂ or 75% Argon/25% CO₂

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Carton Weight (kg)	Pallet Weight (kg)
VacPac			
35BX12248V	1.2	12.5	787.5
35BX16248V	1.6	12.5	787.5

CLASSIFICATIONS	APPROVALS		TYPICAL ALL WELD METAL COMPOSITION (%)			TYPICAL MECH. PROPERTIES ALL WELD METAL		
			Gas	CO ₂	75%Ar/25%CO ₂	As Welded CO ₂	As Welded 75%Ar/25%CO ₂	
<u>SFA/AWS A5.22</u> E308LT0-1/E308LT0-4 <u>EN 12073</u> T199 L R C 3 T199 L R M 3	ABS	E308LT0-1	C	0.030	0.025	Yield Stress, Mpa Tensile Strength, MPa Elongation, %	427	432
	DNV	308L	Mn	1.3	1.5		575	585
	KR	RW308LG	Si	0.6	0.7		42	41
	LR	308L	Cr	19.2	20.1	Charpy V	Test Temp, °C -100	Impact Values* 30
			Ni	9.6	9.6			
			Mo	0.2	0.2			
			FN	9	11			

