

Cryo-Shield 308L

AWS A5.22 E308LT1-1(4) / JIS Z3323 TS308L-FB1

Description and Application

- Cryo-Shield 308L is an all-position flux cored wire adaptable to a variety of shop and field erection applications. Designed for cryogenic applications where good weld metal toughness is required. Applications include cryogenic vessel fabrication and process piping repair.

Cryo-Shield 308L was developed for the welding of types 304 & 304L stainless steels for the low temperature service, even down to liquid helium temperatures. This is done by controlling the composition and the ferrite content to give good toughness at temperatures of -320 °F (-196 °C) and lower.

Cryo-Shield 308L was developed for welding in all positions and performs particularly well in the vertical position with excellent slag removal.

Flux
CORED
WIRES

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal(100%CO₂)

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)
			-196°C
363 {37}	552 {56}	59	41 {4.2}

Typical Undiluted Weld Metal Analysis %(100%CO₂)

C	Mn	Si	P	S	Cr	Ni	Ferrite No.
0.024	1.43	0.67	0.027	0.010	18.50	10.0	Max 8

Approvals

BV, DNV, KR, LR, NK, JIS