

# CA-101S × UC-308/308L

For welding of 18%Cr-8%Ni stainless steel.

UC-308 : AWS ER308

UC-308L : AWS ER308L

## Applications

Welding of 18%Cr-8%Ni Stainless steel and hardfacing welding of 19%Cr-9%Ni stainless steel.

## Characteristics

CA-101S × UC-308/308L is a bonded type flux which contains appropriate quantity of alloy element. Good crack resistibility, good mechanical properties and good corrosion resistibility of weld metal having appropriate ferrite content.

## Notes on usage

- (1) Refer to "General notes on usage for submerged arc welding."
- (2) Avoid using of excessive welding current to prevent deterioration of corrosion resistibility in the heat affected zone.



## Typical chemical composition of weld metal (%)

Flux × Wire	C	Mn	Si	Ni	Cr	Remarks		
						Welding method	Base metal	PT (mm)
CA-101S × UC-308	0.05	1.27	0.85	9.42	19.41	Both side single-layer	SUS 308	15
CA-101S × UC-308L	0.02	1.25	0.86	9.48	19.38			

## Typical mechanical properties of weld metal

Flux × Wire	TS N/mm <sup>2</sup> (MPa)	EL %	IV (J)
			0°C
CA-101S × UC-308	602	41	69
CA-101S × UC-308L	589	42	72

## Typical welding conditions

PT (mm)	Dia. (mT.)	Pass	Amp.	Volt.	Speed (cm/min)	Groove dimension					
						A (mm)	B (mm)	N (mm)	C (°)	D (°)	
11	4.0	1	450	33	55 60		3	3	5	90	90
		2	500	33							
19	4.8	1	650	35	30 35		6	6	7	90	90
		2	800	35							

• Approval : ABS, DNV(UC-308L)