



300 SERIES STAINLESS STEEL FLUX CORED ELECTRODES
3XXT0-1/3XXT0-4 FOR FLAT OR HORIZONTAL WELDING
3XXT1-1/3XXT1-4 FOR ALL POSITION WELDING

WELDING GUIDE

Product Description

Sandvik Flux Cored Electrodes are premium products that are produced to the highest quality standards customers have come to expect from Sandvik Steel Company. Both of these Flux Cored Electrode Products exhibit high operator appeal with very little spatter, easy slag removal and cleanup. These products have the following features and benefits:

Feature	Benefit
Compatible with Argon 20% min CO ₂ or 100% CO ₂	Uses Standard Shielding Gases
Low carbon deposits	Fully alloyed low carbon weld overlays achieved in 2 layers
High deposition rate	50% cost savings over Stick Electrodes
Smooth arc	High operator appeal
Little to no spatter	Very little cleanup
Full slag coverage	Weld does not get heavily oxidized for less cleanup
Self removing slag	Does not pop off during normal welding applications; does not stick to weld
Capable of bridging wide gaps	Compensates for poor fitup
Excellent wash, finely rippled weld bead	Consistent smooth finished looking weld beads
Vacuum sealed packaging	Preserves freshness
304 Sheath	Consistent chemical recovery
Layer level winding	Easy tangle free payoff
Easy to operate	Easy transition for welding operators to a semi-automatic process
X-Ray Quality Welds	Suitable for demanding applications

AWS Designations Explained

An explanation as to how this system applies to Sandvik Flux Cored Electrodes is as follows:

308LTX-X/308LTX-X

The “X” following the “T” refers to the position of welding(1 for all position or 0 for flat or horizontal operation)and the “x” following the dash refers to the shielding medium.

308LTX-1 – CO₂ Shielding Gas

308LTX-4 – 75-80% Argon/remainder CO₂ Shielding Gas

Eg: 309LT0-1/309LT0-4 - Flat or Horizontal Position with 100% or Argon/20-25%CO₂