

JFS-601

CONFORMANCE:

- GB/T 17854:
F308-H0Cr21Ni10, F316L-H00Cr19Ni12Mo2

APPLICATION:

- Subarc welding of austenitic stainless steels such as 308, 309, 347, 316
- Subarc welding of dissimilar joints between carbon steel to stainless steels
- Stainless steel equipment in petrochemical industry
- Chemical ship

PRODUCT FEATURE:

- Agglomerated flux for stainless steel subarc welding
- Basicity Index: 2.8
- Grain size: 10–60 mesh
- Little burn off of Chromium & Nickel during welding, good resistance to intergranular corrosion for weld metal

REDRYING:

- Before welding, if moisture contamination is suspected from either improper storage conditions or due to atmosphere exposure, the flux must be redried at 300 to 350°C for a minimum of 2 hours.

PACKAGE FORM & STANDARD WEIGHT:

- BAG, 30KG
- * Please contact your local lincoln customer service for alternative types indent of packaging.

FLUX COMPOSITIONS, TYPICAL

CaO+MgO	SiO ₂	Al ₂ O ₃ +TiO ₂
47.18%	21.34%	17.14%

CLASSIFICATION

Flux / Wire	GB/T 17854
JFS-601 / JW-308	F308-H0Cr21Ni10
JFS-601 / JW-316L	F316L-H00Cr19Ni12Mo2

WIRE & ALL WELD METAL CHEMICAL COMPOSITIONS (Wt-%), TYPICAL

Wire	C	Mn	Si	P	S	Ni	Cr	Mo
JW-308	0.067	1.78	0.50	0.024	0.010	9.25	20.17	-
JW-316L	0.022	2.09	0.15	0.007	0.003	11.78	18.62	2.28

Weld Metal	C	Mn	Si	P	S	Ni	Cr	Mo
JFS-601 / JW-308	0.055	1.47	0.42	0.024	0.008	9.15	19.89	-
JFS-601 / JW-316L	0.036	1.57	0.32	0.020	0.009	11.39	18.51	2.15

ALL WELD METAL MECHANICAL PROPERTIES, TYPICAL

Flux / Wire	Condition	Yield Strength Rp0.2 (MPa)	Yield Strength Rp1.0 (MPa)	Tensile Strength (MPa)	Elongation (%)	Ferrite Number (Measured by Ferritscope)		
JFS-601 / JW-308	As-welded	445	470	640	42	8.3	8.5	8.1
JFS-601 / JW-316L	As-welded	395	460	555	44	9.0	9.1	8.7

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

Authorized Distributor:

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