

AA 308 LP

CATEGORY FCAW Flux-Cored

TYPE Rutile fluxcored stainless steel welding wire for all positions

APPLICATIONS Boilers, agriculture, liquid storage tanks, food machinery, furniture

PROPERTIES AA 308LP has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion. The fast freezing rutile slag offers excellent welding properties such as wetting and reduce of spatter. The fast freezing slag unables AA 308LP to use a high current in PF position for more economical welding compare to solid wires.

CLASSIFICATION

AWS	A 5.22: E 308 L T 1-4/-1
EN ISO	17633-A: T 19 9 L P M 1
DIN: W.Nr.	1.4316
DIN	8556: 19 9 L

SUITABLE FOR W.Nr:1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452
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 DIN X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNiN 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP),
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 AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN
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 ASTM A320 Grade B8C/D, 302

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL WEIGHT %:

C	Mn	Si	Cr	Ni	N	S	P
<0,03	1,4	0,70	20	10,50	0,014	0,008	0,020

MECHANICAL PROPERTIES:

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-196°C	
AW	460	620	38	>47		>32	

AW; as welded

WELDING PARAMETERS (M21) / PACKING

D (mm)	Welding Parameters		Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0,9	18-27	90-160	D-200 / K-300	5 / 12,5	1000 / 900
1,0	20-28	100-180	D-200 / K-300	5 / 15	1000 / 1080
1,2	23-30	150-220	D-200 / K-300	5 / 15	1000 / 1080

REDRYING TEMPERATURE 150°C/24hr