

AA 308L

CATEGORY	FCAW Flux-Cored																												
TYPE	Rutile flux cored stainless steel welding wire for M21 and Co2 gas.																												
APPLICATIONS	Welding stainless steel types with an alloy content between 16 to 21% Cr and 8 to 13 % Ni, for both stabilized and un-stabilized types. High weld metal quality and a attractive bead appearance.																												
PROPERTIES	<p>Smooth drop transfer and stable arc with no spatter losses.</p> <p>Excellent productivity and weldability, better wetting properties compared to solid wires.</p> <p>Excellent weld metal quality and X-ray soundness and excellent slag removal.</p> <p>Excellent for use in position and down hand as well.</p>																												
CLASSIFICATION	AWS	A5.22: E 308-LT0-1/4																											
	EN ISO	17633-A - T 19 9 L R C/M 3																											
	DIN: W.Nr.	1.4316																											
	DIN	8556: 19 9 L																											
SUITABLE FOR	<p>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</p> <p>DIN X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNi 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP),</p> <p>AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN</p> <p>ASTM A320 Grade B8C/D, 302</p>																												
APPROVALS	TUV (12422.00), CE approved																												
WELDING POSITIONS:																													
WELD METAL WEIGHT %	<table border="1"> <thead> <tr> <th>C</th> <th>Mn</th> <th>Si</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>S</th> <th>P</th> </tr> </thead> <tbody> <tr> <td>0,025</td> <td>1,40</td> <td>0,70</td> <td>20,0</td> <td>10,50</td> <td>-</td> <td>0,008</td> <td>0,020</td> </tr> </tbody> </table>						C	Mn	Si	Cr	Ni	Mo	S	P	0,025	1,40	0,70	20,0	10,50	-	0,008	0,020							
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GAS ACC. EN ISO 14175:	M21, C1																												