

## 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** Smooth drop transfer and stable arc with no spatter losses.  
Excellent productivity and weldability, better wetting properties compared to solid wires.  
Excellent weld metal quality and X-ray soundness and excellent slag removal.  
Excellent for use in position and down hand as well.

**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** 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  
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),  
AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN  
ASTM A320 Grade B8C/D, 302

**APPROVALS** TUV (12422.00), CE approved

**WELDING POSITIONS:**



**WELD METAL WEIGHT %**

C	Mn	Si	Cr	Ni	Mo	S	P
0,025	1,40	0,70	20,0	10,50	-	0,008	0,020

**MECHANICAL PROPERTIES**

Gas Type	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-196°C	
M21	460	620	36			>30	

**WELDING PARAMETERS PACKING**

D (mm)	Welding Parameters		Packing		
	Voltage (V)	Current (A) (DC+)	spool type	kg / spool	kg / pallet
0,9	18-28	80-180	D-200 / KD-300	5 / 12,5	1000 / 1080
1,2	23-35	100-270	D-200 / KD-300	5 / 15	1000 / 1080

**REDRYING TEMPERATURE** 150°C / 24hr

**GAS ACC. EN ISO 14175:** M21, C1