



CEWELD AA 308 L

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.

CLASSIFICATION

| | |
|--------|---------------------------|
| AWS | A 5.22: E308LT0-4 |
| EN ISO | 17633-A: T 19 9 L R M21 3 |
| W.Nr. | 1.4316 |
| F-nr | 6 |
| FM | 5 |

SUITABLE FOR **19%Cr, 9%Ni Type, ISO 15608: 8.1 TÜV 1000: Gr. 21 - 22 (29 max.350°C),**
 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
 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,

APPROVALS TÜV: 12422.00, CE

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | Cr | Ni | S |
|-------|-----|-----|-------|----|----|-------|
| 0.025 | 0.7 | 1.4 | 0.015 | 19 | 10 | 0.008 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
| | | | | -60°C | -196°C | |
| As Welded | 460 | 620 | 36 | 80 | 35 | HRc |

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M21