



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, A 5.22: E308LT0-1					
	EN ISO	17633-A: T 19 9 L R M21 3, 17633-A: T 19 9 L R C1 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	CE						
WELDING POSITIONS	 PA  PB  PC  PF						
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						