



FCW 308L

*High productivity 308L type
Flux cored wire*

Classification

AWS A5.22 : E308LT0-1/-4

ISO 17633-A : T 19 9 L R M21(C1) 3

Description & Applications

Flux cored wire for gas shielded (Ar + CO₂) arc welding for 304L stainless steel. Flux cored wire with high productivity in down hand and fillet welding. Easy slag removal. For all type of steel construction with a service temperature does not exceed 400°C.

Main applications: Thermal Plant, piping, construction on sea coast

Base materials:

UNS	Grade	EN 10088	N° Mat.
S30400	304	X5CrNi18-10	1.4301
S30403	304L	X2CrNi19-11	1.4306
S32100	321	X6CrNiTi18-10	1.4541
S34700	347	X6CrNiNb18-10	1.4550

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	P	S
Min			0.5	18.0	9.0				
Max	0.04	1.0	2.0	21.0	11.0	0.30	0.5	0.030	0.025
Type	0.03	0.70	1.4	19.5	10.6	0.01	0.10	0.020	0.008

FN 8 (Feritscope)

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	320	520	30	
Max				
Type	400	560	40	+20°C : 50 -196°C : 32

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	

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