

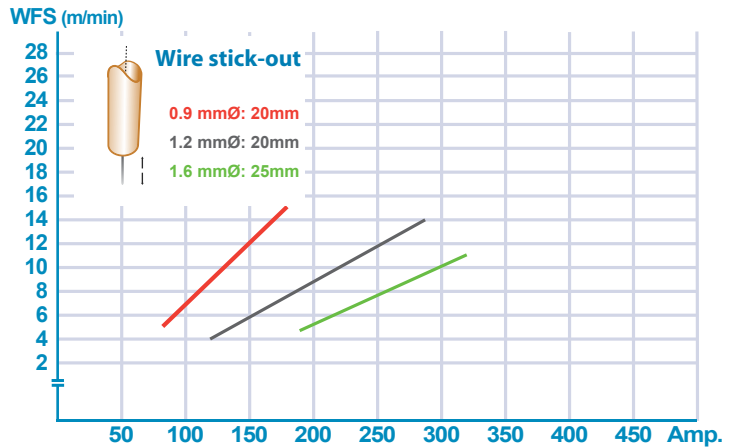
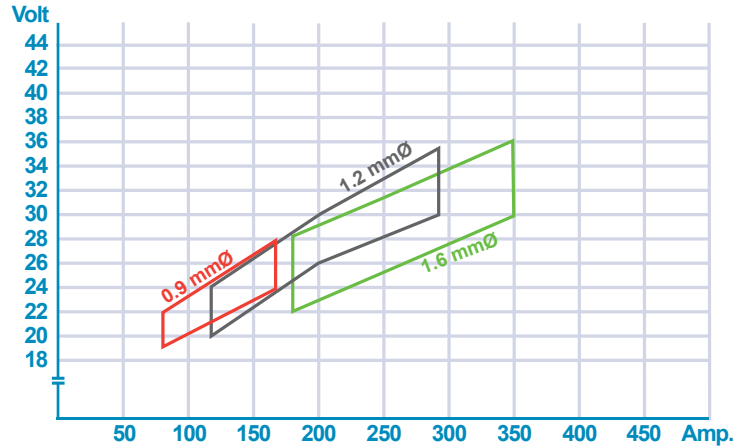
80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A-T 19 9 L R C/M 3
 AWS A5.22 E308LT0-1/4
 EN 1.4316

Description and Application

This is rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire is designed for welding 18%Cr-10%Ni type stainless steels like type 304L or EN 1.4307. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.60	1.60	0.020	0.005	10.1	19.7	-	-	-	8.9	12.4	10.8

Typical Mechanical Properties*

	R _c (MPa)	R _m (MPa)	A ₅ (%)	CV (J)-20°C
Guarantee	min.320	min.520	min.30	45

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
304L	308L	-	4550S	MG	-	TÜV,DB,CWB

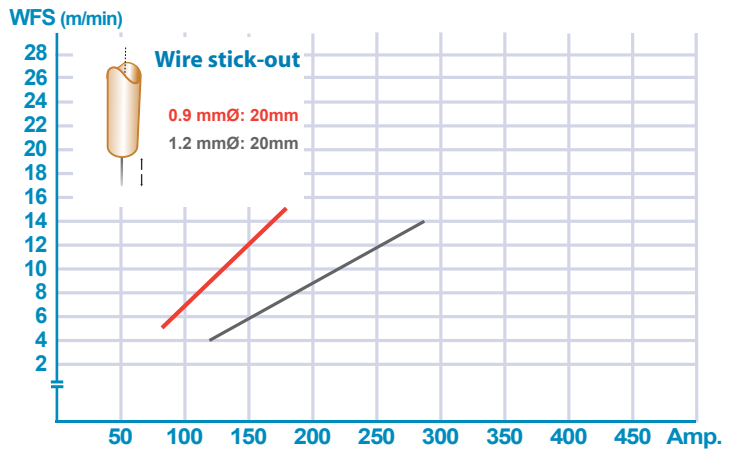
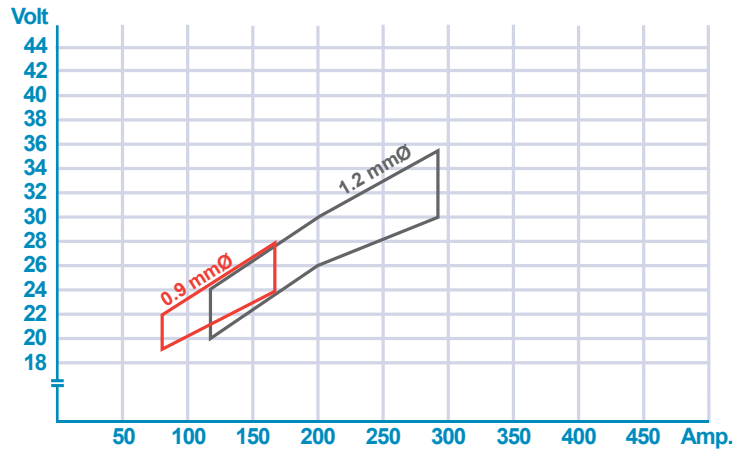
80%Ar - 20%CO₂ / 100%CO₂
 EN ISO 17633-A-T 19 9 L P C/M 1
 AWS A5.22 E308LT1-1/4
 EN 1.4316

Description and Application

This is rutile flux cored wire which operates with very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire is designed for welding 18%Cr-10%Ni type stainless steels like type 304L or EN 1.4307. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.

Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

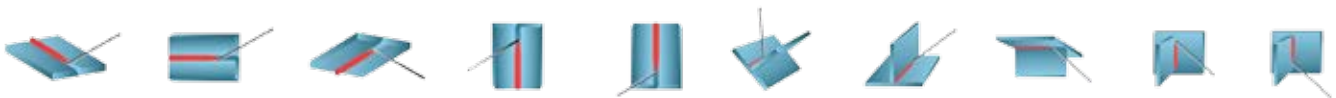
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.70	1.70	0.019	0.004	9.9	19.5	-	-	-	9.0	12.5	10.3

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J) -20°C
	410	580	41	50
Guarantee	min.320	min.520	min.30	

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
-	-	-	4550S	E 308LT1-4 MG	-	DB,CWB,TÜV