
# CEWELD AA 308 L

certilas® THE FILLER METAL SPECIALIST

**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 |
| AWS | A 5.22: E308LT0-1 |
| EN ISO | 17633-A: T 19 9 L R M21 3 |
| EN ISO | 17633-A: T 19 9 L R C1 3 |
| F-nr | 6 |
| FM | 5 |
| W.Nr. | 1.4316 |

**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 |

**ALL WELD MECHANICAL PROPERTIES**

| Heat Treatment | $R_{P0,2}$ MPa | Rm MPa | A5 (%) | Impact Energy (J) ISO-V -60°C | Impact Energy (J) ISO-V -196°C |
|---|---|---|---|---|---|
| As Welded / | 460 | 620 | 36 | 80 | 35 |

**REDRYING TEMPERATURE**

140°C / 24 hr

**GAS ACCORDING EN 14175**

M21