



# 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	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: E308LT0-4</td> </tr> <tr> <td>AWS</td> <td>A 5.22: E308LT0-1</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 19 9 L R M21 3</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 19 9 L R C1 3</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4316</td> </tr> </table>	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			
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SUITABLE FOR	<p><b>19%Cr, 9%Ni Type, ISO 15608: 8.1 TÜV 1000: Gr. 21 - 22 (29 max.350°C),</b>            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,</p>																	
APPROVALS	CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.025</td> <td>0.7</td> <td>1.4</td> <td>0.015</td> <td>19</td> <td>10</td> <td>0.008</td> </tr> </tbody> </table>	C	Si	Mn	P	Cr	Ni	S	0.025	0.7	1.4	0.015	19	10	0.008			
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REDRYING TEMPERATURE	140°C / 24 hr																	
GAS ACCORDING EN 14175	M21																	