




CEWELD AA 308LM

TYPE	Metal cored stainless steel welding wire.(Type 308L, 19 9L)					
APPLICATIONS	CEWELD® AA 308LM is suitable for welding stainless steels with an alloy content between 16 to 21% Cr and 8 to 13% Ni, stabilised or not. Boilers, tanks, agriculture, liquid storage tanks, food machinery, furniture.					
PROPERTIES	CEWELD® AA 308LM has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion. Enhanced productivity, improved weldability, better wetting properties compared to solid wires. Excellent weld metal quality and X-ray soundness.					
CLASSIFICATION	AWS	A 5.22: EC308L				
	EN ISO	17633-A: T 19 9 L M M12 1				
	F-nr	6				
	FM	5				
	W.Nr.	1.4316				
SUITABLE FOR	ISO 15608: 8.1 Austenit ≤ 19 % Cr 9% Ni ,TÜV 1000: Gr. 21 - 22 (29 max.350°C), 1.4301, 1.4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550 X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10 AISI 304, 304H, 312, 321H, 347, 347H, UNS S30409, S32109, S34709, S30400, S32100, S34700					
APPROVALS	CE					
WELDING POSITIONS						
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S	Cr Ni
	0.02	0.55	1.4	0.015	0.008	21 11
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V -196°C	
	As Welded /	430	600	40	35	
REDRYING TEMPERATURE	Not required					
GAS ACCORDING EN 14175	I1, M13, M12					