




# 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	AWS	A 5.22: E308LT0-4																
	EN ISO	17633-A: T 19 9 L R M21 3																
	W.Nr.	1.4316																
	F-nr	6																
	FM	5																
SUITABLE FOR	<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,																	
APPROVALS	TÜV: 12422.00, CE																	
WELDING POSITIONS																		
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <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			
C	Si	Mn	P	Cr	Ni	S												
0.025	0.7	1.4	0.015	19	10	0.008												
MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>-60°C</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>460</td> <td>620</td> <td>36</td> <td>80</td> <td>35</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	-60°C	-196°C	As Welded	460	620	36	80	35	HRc	
Heat Treatment	R <sub>P0,2</sub> (MPa)					R <sub>m</sub> (MPa)	A <sub>5</sub> (%)		Impact Energy (J) ISO-V		Hardness							
		-60°C	-196°C															
As Welded	460	620	36	80	35	HRc												
REDRYING	140°C / 24 hr																	
GAS ACC. EN ISO 14175	M21																	