CEWELD AA 308LM

certilas® THE FILLER METAL SPECIALIST

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
W.Nr.	1.4316
F-nr	6
FM	5

SUITABLE FOR

ISO 15608: 8.1 Austenitic ≤ 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

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -196°C	Hardness
As Welded	430	600	40	35	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

I1, M13, M12