




# CEWELD AA 308 L

| TYPE  | Fil fourré rutile 308L en acier inoxydable pour M21 et gaz Co2.  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
|---|--|----------------|-------------------------|----------------------|---------------------------|-------------------------|--------------------|----------|-------------------------|--------|-----------|-------|-----|----|-------|----|-----|
| APPLICATIONS                                | Soudage des types d'acier inoxydable dont la teneur en alliage est comprise entre 16 et 21 % de Cr et 8 et 13 % de Ni, pour les types stabilisés et non stabilisés. Qualité élevée du métal déposé et aspect attrayant du cordon.  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
| PROPRIÉTÉS                                  | Transfert de gouttes lisse et arc stable sans pertes de projections. Excellente productivité et soudabilité, meilleures propriétés de mouillage par rapport aux fils solides. Excellente qualité du métal déposé et de la radiographie et excellent enlèvement du laitier. Excellent pour l'utilisation en position et a plat  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
| CLASSIFICATION                              | <table border="0"> <tr> <td>AWS</td> <td>A 5.22: E308LT0-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 19 9 L R M21 3</td> </tr> <tr> <td>W.Nr.</td> <td>1.4316</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>   | 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         |       |     |    |       |    |     |
| 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  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
| CONVIENT POUR                               | <p><b>19%Cr, 9%Ni Type, ISO 15608: 8.1 TÜV 1000: Gr. 21 - 22 (29 max.350°C),</b><br/>           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<br/>           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)<br/>           AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN,<br/>           ASTM A320 Grade B8C/D,</p>  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
| AGRÉMENTS                                   | TÜV: 12422.00, CE  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
| POSITIONS DE SOUDAGE                        |   |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
| 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                   |                    |          |                         |        |           |       |     |    |       |    |     |
| PROPRIÉTÉS MÉCANIQUES                       | <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                     |                    |          |                         |        |           |       |     |    |       |    |     |
| ETUVAGE                                     | 140°C / 24 hr  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |
| GAS ACC. EN ISO 14175                       | M21  |                |                         |                      |                           |                         |                    |          |                         |        |           |       |     |    |       |    |     |