



# FCW 308L

High productivity 308L type  
Flux cored wire

## Classification

AWS A5.22 : E308LT0-1/-4

ISO 17633-A : T 19 9 L R M21(C1) 3

## Description & Applications

Flux cored wire for gas shielded (Ar + CO<sub>2</sub>) arc welding for 304L stainless steel. Flux cored wire with high productivity in down hand and fillet welding. Easy slag removal. For all type of steel construction with a service temperature does not exceed 400°C.

**Main applications:** Thermal Plant, piping, construction on sea coast

### Base materials:

UNS	Grade	EN 10088	N° Mat.
S30400	304	X5CrNi18-10	1.4301
S30403	304L	X2CrNi19-11	1.4306
S32100	321	X6CrNiTi18-10	1.4541
S34700	347	X6CrNiNb18-10	1.4550

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.03	0.70	1.4	19.5	10.5	0.01	0.10	0.02	0.008	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	
400	560	40	+20°C	60
			-196°C	32

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 280	23 - 33	10 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 12 - 20 l/min
	1.6	150 - 400	23 - 35	10 - 25	



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