



# 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** **19%Cr, 9%Ni Type, ISO 15608: 8.1 TÜV 1000: Gr. 21 - 22 (29 max.350°C),**  
 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 (%)**

C	Si	Mn	P	Cr	Ni	S
0.025	0.7	1.4	0.015	19	10	0.008

**MECHANICAL PROPERTIES**

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