



# CEWELD AA 308LM

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	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: EC308L</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 19 9 L M M12 1</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: EC308L	EN ISO	17633-A: T 19 9 L M M12 1	W.Nr.	1.4316	F-nr	6	FM	5						
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SUITABLE FOR	<p><b>ISO 15608: 8.1 Austenitic ≤ 19 % Cr 9% Ni ,TÜV 1000: Gr. 21 - 22 (29 max.350°C),</b>            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</p>																
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TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.55</td> <td>1.4</td> <td>0.015</td> <td>0.008</td> <td>21</td> <td>11</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	0.02	0.55	1.4	0.015	0.008	21	11		
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REDRYING	Not required																
GAS ACC. EN ISO 14175	I1, M13, M12																