CEWELD AA 308 LP

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile flux cored stainless steel welding wire for all positions. (Type T 19 9 L P / E308LT)1

APPLICATIONS

CEWELD® AA 308LP for welding stainless steels similar to 1.4307 / 304L with good corrosion resistance Boilers, agriculture, liquid storage tanks, food machinery, furniture

PROPERTIES

CEWELD® AA 308LP has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion. The fast freezing rutile slag offers excellent welding properties such as wetting and reduce of spatter. Excellent for use in position and down hand as well. The fast freezing slag unables CEWELD® AA 308LP to use a high current in PF position for more economical welding compare to solid wires.

CLASSIFICATION

AWS	A 5.22: E308LT1-4, A 5.22: E308LT1-1
EN ISO	17633-A: T 19 9 L P M21 1
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

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Mo	S	FN	FS	FNW
0.03	0.7	1.4	0.015	20	10	0.3	0.008	10	7	7

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				-20°C	-196°C	
As Welded	460	620	38	50	35	HRc

REDRYING

140°C / 24 hr

GAS ACC. EN ISO 14175

M21