

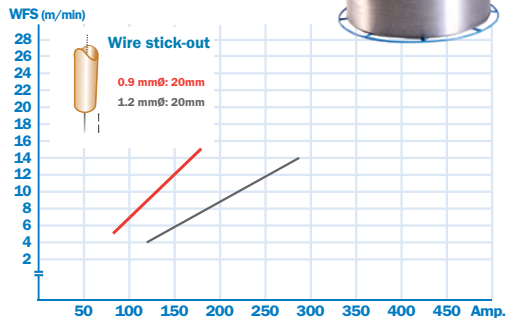
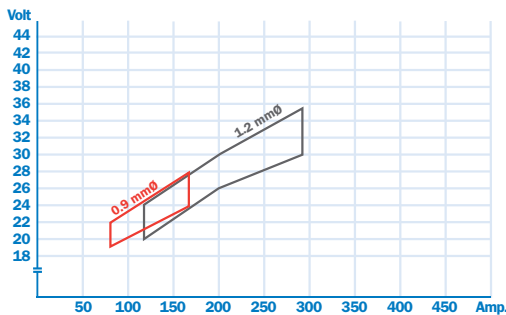
Description and Application

This is rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire is designed for welding 18%Cr-10%Ni type stainless steels like type 304L or EN 1.4307. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

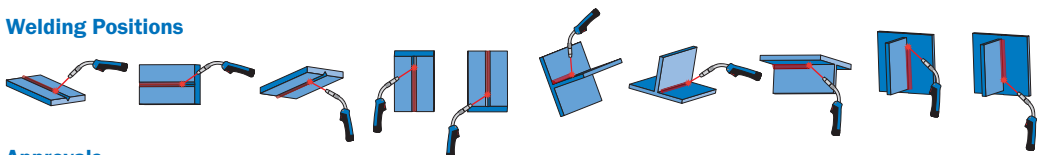
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.70	1.70	0.019	0.004	9.9	19.5	-	-	-	9.0	12.5	10.3

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)+20°C	CV(J)-20°C
Guaranty	410	580	41	60	51
	min.320	min.520	min.30		

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
-	VL308L	-	E 308LT1-4/ MG (C1)	-	TÜV, DB, CWB, RINA, CE