

Standards

TS EN ISO 17633-A	: T 19 9 L P M21/C1 1
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AWS A5.22	: E 308 L T1-1/-4

**Chemical Composition of
Weld Metal (Typical)**

C	Si	Mn	Cr	Ni
0.03	0.70	1.40	20.0	10.5

Mechanical Properties - (Typical): (With M21 gas)

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-196°C)	Elongation (L _o =5d _o) (%)
460	620	34 J	36

Typical Base Material Grades

- (1.4306) X2CrNi19-11, (1.4301) X5CrNi18-10, (1.4311) X2 CrNiN 18-10, (1.4312) GX10CrNi18-8)
- AISI 304-304L-304LN, 302, 321-347, ASTM: A 157, Gr C9, A 320 Gr B8C or D

Features and Applications

- Rutile type, rapid hardening flux cored wire
- Weld metal structure is austenitic (CrNi alloyed, 308 type)
- Used in pharmaceutical, paper and food industry
- Ferritic stainless steel, high carbon 304 and stabilized 347 grades can be welded this wire
- Weld metal has resisting between -196°C and 400°C service temperature
- Shielding Gas: CO₂ or M21

Welding Positions

Current Type

FCAW / D.C (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100255	1.20	0.047"	15	D 300

Approvals: ELOXCOR S 308 L (CO₂): DNV-GL, CE, SEPRO