

COREFIL 308LP

Flux cored wires [FCAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 17633-A : T 19 9 LP C1 (M21) 1 DIN 8556 : 19 9 L AWS A-5.22 : E 308LT1-1/4 W.Nr. : 1.4316		Power generation industry Constructions & Engineering Petrochemical and chemical industry

- Rutile flux cored wire for all-position welding of 18% Cr - 10% Ni type stainless steels, as well as Nb and Ti stabilized steels, provided that the working temperature does not exceed 350°C.
- High weld metal performance.
- Excellent operating properties, very stable arc, very easy slag release.
- The weld deposit shows high resistance to intergranular corrosion.
- The increased feed rates, as well as the minimal cleaning and pickling requirements, provide significant time and cost savings.
- Especially recommended for high-performance welding in forced positions.
- Creates a light joint with a very fine scale.

Base material



AISI/ASTM	EN 10088-1/2	EN 10213-4	W.Nr.	PN
304L	X2 CrNi 18 11		1.4306	00H18N10
204LN	X2 CrNiN 18 10		1.4311	
	X4 CrNi 18 10	GX5 CrNi 19 10		
	X6 Cr 13		1.4308	
304	X5 CrNi 18 10		1.4301	0H18N9
321	X6 CrNiTi 18 10		1.4541	1H18N9T
347	X6 CrNiNb 18 10		1.4550	H18N12Nb
		GX5 CrNiNb 19 10	1.4552	
302	X12 CrNi18 8		1,4300	
305		GX10 CrNi 18 8	1.4312	
304H	X6 CrNi18 11		1.4948	
308	X5 CrNi18 11		1.4303	
347	X5 CrNiNb18 9		1.4543	
301			1.4310	1H18N9
	X10 CrNiNb18 10		1.6905	
405	X7 CrAl13		1.4002	
410	X10 Cr13		1.4006	
430	X8 Cr17		1.4016	
410/420	X15 Cr13		1.4024	
420	X20 Cr13		1.4021	

Typical chemical composition %

C	Si	Mn	Cr	Ni
0,03	0,60	1,45	20,00	9,80

Typical mechanical properties

Yield strength Re [N/mm2]	415
Tensile strength Rm [N/mm2]	570

Elongation A5 [%]	42
Impact energy Kv [J]	54J (0°C) / >32J (-196°C) /
Wire/rod type	flux cored
Flux type	rutile
Welding current	
Welding positions	
Additional description	Gas flow 15-20[l/min]
Shielding gases acc. to EN ISO 14175	C1 - 100% CO2 / M21 - Ar + 15 - 25% CO2 /

Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Gas flow	Weight of packet [kg]
1,2	130 - 280	21 - 34	20 - 25	15,0

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