Cor-A-Rosta® 304L

CLASSIFICATION

AWS A5.22	E308LT0-1/-4	**A-Nr**	8	**Mat-Nr**	1.4316
ISO 17633-A	T 19 9 L R C/M 3	**F-Nr**	6		
		9606 FM	5		

GENERAL DESCRIPTION

Gas shielded flux cored stainless steel wire electrode for downhand welding
Stable arc, low spatter and good slag removal
Excellent wire feeding and operator appeal
Bright appearance of weld metal

WELDING POSITIONS (ISO/ASME)

PA/1G **PB/2F** **PC/2G**

CURRENT TYPE / SHIELDING GAS (ISO 14175)

DC +
M21 : Mixed gas Ar+ (>15-25%) CO_2
C1 : Active gas 100% CO_2
Flow rate : 15-25 l/min

APPROVALS

Shielding gas	DNV	GL	LR	TÜV
M21	308LMS	4550S		+
C1	308LMS		304L	+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc.WRC 1992)
M21 /C1	0.03	1.3	0.7	19.5	10	8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm²)	Tensile strength (N/mm²)	Elongation (%)	Impact ISO-V(J) +20°C	Impact ISO-V(J) -110°C
Required: AWS A5.22			not required	min.520	min. 35		
ISO 17633-A			min. 320	min. 510	min. 30		
Typical values	M21/C1	AW	400	560	42	80	40

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	**1.2**
15 kg spool S300	X

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EXAMPLES OF EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Extra low carbon (C <0.03%)					
	X2CrNi19-11		1.4306	(TP)304L	S30403
				CF-3	J92500
	X2CrNiN18-10		1.4311	(TP)304LN	S30453
				302,304	S30400
Medium carbon (C >0.03%)					
	X4CrNi18-10		1.4301	(TP)304	S30409
		G-X5CrNi19-10	1.4308	CF 8	J92600
Ti-, Nb stabilized					
	X6CrNiTi18-10		1.4541	(TP)321	S32100
				(TP)321H	S32109
	X6CrNiNb18-10		1.4550	(TP)347	S34700
				(TP)347H	S34709
		G-X5CrNiNb19-10	1.4552	CF-8C	J92710

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions PA/1G	PB/2F	PC/2G
1.2	100-250A	100-250A	100-200A

REMARKS/APPLICATION ADVICE

For positional welding, use Cor-A-Rosta P304L