CEWELD AA 308L Tig

certilas® THE FILLER METAL SPECIALIST

TYPE	Flux cored stainless steel welding wire for Tig welding. (Type 19 9 L / 308L)
APPLICATIONS	Boilers, shipbuilding, machinery, offshore application, foundries, chemical industry, root pass welding when backing gas is not available or prefered.
PROPRIÉTÉS	Flux cored wire with slag support for high productivity welding especialy for root welding. The slag is self detaching and offers a unique protection against oxidation on the reverse side of the root pass. Saving the cost for back shielding gas and purging time makes CEWELD AA 308L Tig a very economical option.

CLASSIFICATION

AWS	A 5.22: R308LT1-5
F-nr	6
FM	5

CONVIENT POUR

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,

AGRÉMENTS: CE

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu	Nb+Ta
0.011	0.75	1.45	0.018	0.003	19	11	0.04	0.02	0.05	0.01

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded		600	45	HRc

ETUVAGE: Not required

GAS ACC. EN ISO 14175: I1