

Cored Wires Stainless and Heat resistant steels

Fluxinox 308L is an alloyed rutile flux cored wire for the welding of unstabilized and stabilized corrosion resistant Cr Ni-steels. Suitable for operating temperatures up to 350 °C, non-scaling up to approximately 800 °C. FLUXOFIL 308 L features outstanding, almost spatter-free, welding properties. Very easy slag removal from fillet welds. Flat and smooth weld beads without undercut. Due to little discoloration of the weld beads, pickling costs can be minimised.

Classification	
AWS	A5.22: E308LT0-4 / E308LT0-1
EN	12073: T 19 9 L R M 3 / T 19 9 L R C 3

Approvals	Grades
ABS	
BV	
DB	
DNV	
GL	
LRS	
TÜV	
UDT	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
≤ 0.04	1.40	0.60	-	-	20	10	-	-	-	-	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 196 °C	Hardness
As Welded	≥ 350	≥ 520	≥ 35	≥ 32	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or C1(Arcal 2)

Materials

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

AISI 304 - 304L - 302

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB PC

Packaging data: K300 kg. 16

Diameters	1,0	1,2			