

# FLUXINOX 308L-PF

## Cored Wires Stainless and Heat resistant steels

Fluxinox 308L-PF is an alloyed rutile flux cored wire with a fast-freezing slag 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. Fluxinox 308L-PF exhibits outstanding, almost spatter-free, welding properties with very easy slag removal from fillet welds resulting in flat and smooth weld beads without undercut into the base metal. Due to only slight discoloration of the weld beads, pickling costs can be minimised. Due to the fast-freezing slag of Fluxinox 308L-PF, it is well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.

Classification	
AWS	A5.22: E308LT1-4 / E308LT1-1
EN	12073: T 19 9 L P M 1 / T 19 9 L P C 1

Approvals	Grades
TÜV	

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 <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 196 °C	Hardness
As Welded	≥ 320	≥ 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 PF PE

**Packaging data:** K300 kg, 16

Diameters	1,0	1,2				
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