

# MIGINOX FC 308L

FCAW STAINLESS STEEL

AWS A/SFA 5.22 **E308LT1-4**

## CLASSIFICATION:

**EN ISO 17633-A**  
T 19 9 L P C1 2  
T 19 9 LP M21 2

## KEY FEATURES:

- Rutile based extra low carbon gas shielded stainless steel FCAW wire
- Typical 19Cr-10Ni weld deposit
- Stable arc, low spatter and easy slag removal
- Excellent bead appearance
- Excellent crack resistance and corrosion resistance
- Radiographic weld quality

**APPROVALS:** RDSO Class VI/CE

## TYPICAL APPLICATIONS:

- Welding of 18Cr-8Ni stainless steels of AISI 301, 302, 304, 304L type
- Application in Chemical, Food processing industries, Pipes & tubes



## CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.04 max	0.50-2.50	1.0 max	18.0-21.0	9.0-11.0	0.5 max

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

## PARAMETERS - PACKING DATA:

Ø, mm	Kg/Spool		
1.2	12.5	 <b>DCEP</b>	All Positions, Except Vertical Down: 
1.6	12.5		
		<b>STORAGE / HANDLING :</b> Keep dry and follow handling instructions mentioned on the box	

Shielding Gas	Gas Flow Rate, LPM
80Ar+20CO <sub>2</sub>	18-25

It can work with CO<sub>2</sub> shielding gas.