

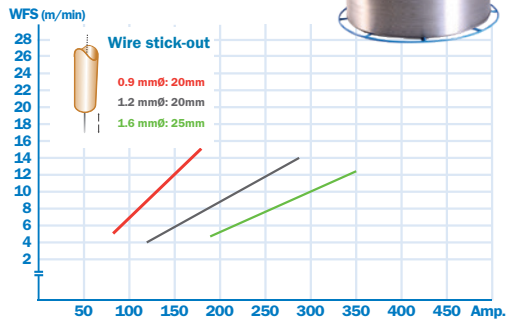
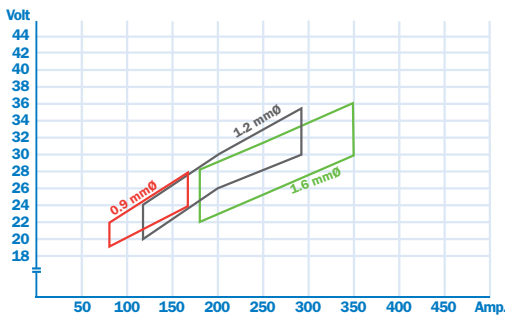
## Description and Application

This is rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire is designed for welding 18%Cr-10%Ni type stainless steels like type 304L or EN 1.4307. Due to the low carbon content in the weld metal, it is possible to obtain high resistance to intergranular corrosion.



### Recommended Parameter Range, for flat position\*



### Typical Chemical Analysis (wt. %)

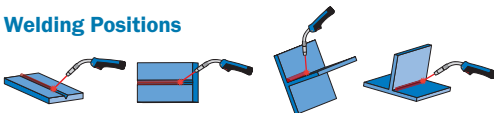
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.60	1.60	0.020	0.005	10.1	19.7	-	-	-	8.9	12.4	10.8

### Typical Mechanical Properties\*

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-20°C
Guaranty	min.320	min.520	min.30	45

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
304L	VL 308 L	-	MG	-	TÜV, DB, CWB