

MX-A308L

80%Ar - 20%CO₂

AWS A5.22 EC308L

MX-A309L

80%Ar - 20%CO₂

AWS A5.22 EC309L

MX-A309MoL

80%Ar - 20%CO₂

AWS A5.22 EC309ML

MX-A316L

80%Ar - 20%CO₂

AWS A5.22 EC316L

Description and Application

These are metal cored stainless steel wires which can be used at higher amperage than rutile flux cored wires. These PREMIARC™ series metal cored wires provide superior weldability, deposition rate and bead appearance compare to that of solid wires.

MX-A308L : For 18%Cr-8%Ni stainless steels.

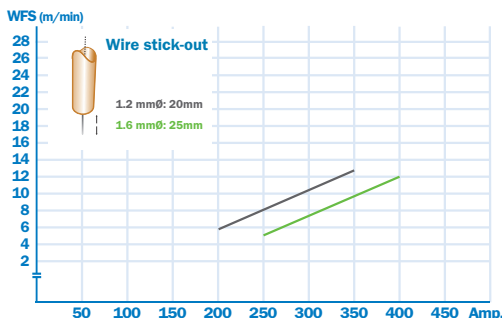
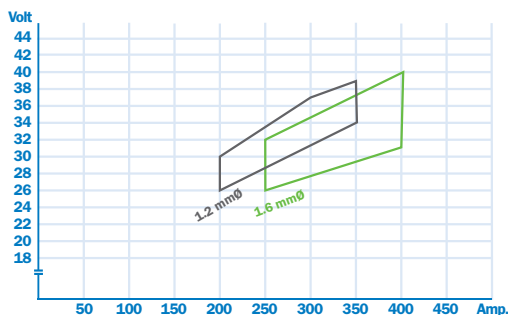
MX-A309L : For dissimilar metal and first layer in cladding.

MX-A309MoL : For dissimilar metal and first layer in cladding.

MX-A316L : For 18%Cr-12%Ni-2%Mo type stainless steels.



Recommended Parameter Range, for flat position



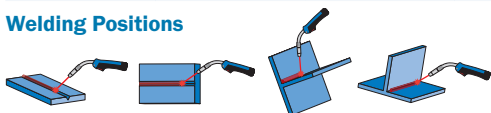
Typical Chemical Analysis (wt. %)

	C	Si	Ni	Cr	Mo	N	FS
MX-A308L	0.025	0.60	10.20	20.05	0.10	0.027	9.00
MX-A309L	0.025	0.62	12.38	24.06	0.10	0.028	14.00
MX-A309MoL	0.025	0.64	12.38	23.07	2.41	0.028	18.00
MX-A316L	0.025	0.49	12.18	18.99	2.23	0.028	6.5

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J)	°C
MX-A308L	400	570	45	93	0
MX-A309L	440	600	35	-	-
MX-A309MoL	505	705	33	-	-
MX-A316L	415	580	30	81	0

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-