



# CEWELD AA 308 LP

**TYPE** Rutile flux cored stainless steel welding wire for all positions. (Type T 19 9 L P / E308LT )1

**APPLICATIONS** CEWELD® AA 308LP for welding stainless steels similar to 1.4307 / 304L with good corrosion resistance Boilers, agriculture, liquid storage tanks, food machinery, furniture

**PROPERTIES** CEWELD® AA 308LP has good general corrosion resistance. The alloy has a low carbon content, making it particularly recommended where there is a risk of intergranular corrosion. The fast freezing rutile slag offers excellent welding properties such as wetting and reduce of spatter. Excellent for use in position and down hand as well. The fast freezing slag unables CEWELD® AA 308LP to use a high current in PF position for more economical welding compare to solid wires.

**CLASSIFICATION**

|        |                                      |
|--------|--------------------------------------|
| AWS    | A 5.22: E308LT1-4, A 5.22: E308LT1-1 |
| EN ISO | 17633-A: T 19 9 L P M21 1            |
| W.Nr.  | 1.4316                               |
| F-nr   | 6                                    |
| FM     | 5                                    |

**SUITABLE FOR** **19%Cr, 9%Ni Type, ISO 15608: 8.1 TÜV 1000: Gr. 21 - 22 (29 max.350°C),**  
 1.4306, 1.4301, 1.4541, 1.4550, 1.4311, 1.4546, 1.4312, 1.4300, 1.4312, 1.4371, 1.4541, 1.4543, 1.4550, 1.4452  
 X2CrNi 19 11 (TP), X4CrNi 18 10 (TP), X6CrNiTi 18 10 (TP), X6CrNiNb 18 10 (TP), X2CrNiN 18 10 (TP), X5CrNiNb 18 10, G-X10CrNi 18 8 (TP)  
 AISI 202, 302, 304L, 304, 305, 321, 347, 304 LN,  
 ASTM A320 Grade B8C/D,

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C    | Si  | Mn  | P     | Cr | Ni | Mo  | S     | FN | FS | FNW |
|------|-----|-----|-------|----|----|-----|-------|----|----|-----|
| 0.03 | 0.7 | 1.4 | 0.015 | 20 | 10 | 0.3 | 0.008 | 10 | 7  | 7   |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | -20°C                   | -196°C |          |
| As Welded      | 460                     | 620                  | 38                 | 50                      | 35     | HRc      |

**REDRYING** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21