



# DAIKOFCW 308L



AUSTENITIC STAINLESS STEELS  
308L

## DESCRIPTION

### Rutile flux cored wire for flat and horizontal position

Austenitic rutile flux cored wire for welding and cladding in flat and horizontal position. The easy handling and the high deposition rate result in high productivity, excellent welding performance and very low spatter formation. The self-releasing slag makes cleaning and pickling easier providing together with increased travel speeds noticeable savings in time and costs. The wire shows good wetting behaviour and a finely rippled surface pattern. These consumables are used to weld 304L stainless steels (18Cr/8Ni) base materials.

## SPECIFICATIONS

ISO 17633-A	T 19 9 L R C1/M21 3	AWS A5.22	E308LT0-1/4
DIN	-	Werkstoff Number	-
Certifications	CE, TUV	Shielding	M21, C1
Positions	PA, PB, PC	Current	DC+

## ASME QUALIFICATIONS

F-No (QW432)	6
A-No (QW442)	8

## FERRITE

3-12 FN
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## PREN

19.83
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## HARDNESS

76HRB
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## CHEM. COMP. %

	DEFAULT
C	0.02
Mn	1.6
Ni	10
Cr	19.5
P	0.02
S	0.01
Mo	0.1
Si	0.6

## MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength $R_m$ MPa	510	520
Yield strength $R_{p0.2}$ MPa	320	340
Elongation A ( $L_0=5d_0$ ) %	30	40
Impact Charpy ISO-V	-	40J @ -20°C
Impact Charpy ISO-V	-	-

## WELDING PARAMETERS

	1.2 mm	1.6 mm
Ampere	120A - 280A	200A - 350A
Voltage	22V - 30V	26V - 30V
Packaging	Ø 1,2÷1,6mm	Ø 1,2÷1,6mm
Packaging Type	BS300 spool	BS300 spool

V 01/2024



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit [www.daikowelding.com](http://www.daikowelding.com).





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DESCRIPTION

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## APPLICATION

Engineered for welding 18Cr/8Ni stainless steels, encompassing 301, 302, 303, nitrogen-bearing 304LN, and titanium-stabilized 321, these welding consumables offer versatile performance. They perform well in service temperatures ranging from -100°C to about 400°C, making them suitable for applications in food, brewery, pharmaceutical equipment, architectural and general fabrication, as well as nuclear engineering. It's important to note that these consumables, specifically 308L, are not recommended for elevated temperature structural applications involving 304/304H; refer to 308H for such applications. For cryogenic use at -196°C, consult 308LCF. No preheating is required, and the recommended maximum interpass temperature is 250°C, with no post-weld heat treatment necessary.

## ALLOY TYPE

308L austenitic stainless steels for joining 304L base materials.

## MICROSTRUCTURE

Austenite with a controlled level of ferrite, normally in the range 3-12FN depending on the application.

## MATERIALS

**EN W.Nr.:** 1.4306 (X2CrNi19-11), 1.4301 (X5CrNi18-10), 1.4311 (X2CrNi18-10), 1.4308 (X5CrNi19-10), 1.4541 (X6CrNiTi18-10), 1.4543 (X 3 CrNiCuTi 12-9), 1.4561 (X1CrNiMoTi18-13-2), 1.4550 (X6CrNiNb18-10)+

**ASTM:** 304L, 304, 304LN, CF3, CF8, 321, 347.

**UNS:** S30403, S30400, S30453, S32100, S34700.

