Cor-Revicod® 308LT0

Stainless rutile cored wire

Classification

AWS A5.22	:E 308LT0-1/-4
ISO 17663	:T 19 9 L R C/M 3

General description

Gas shielded flux cored stainless steel wire electrode for welding in downhand position
Stable arc, low spatter and good slag removal
Excellent wire feeding and operator appeal
Bright appearance of weld metal

Welding positions

ISO/ASME PA/1G PB/2F PC/2G

Current type / Shielding gases

DC +
Ar+(>5-25)% CO_2 (EN 439:M21)
100% CO_2 (EN 439:C1)
15-25 l/min

Approvals

Shielding gases	DNV	GL	LR	TÜV
M21	308LMS	4550S		+
C1	308LMS		304L	+

Typical chemical composition of all weld metal, (w%)

Shielding gases	C	Mn	Si	Cr	Ni	FN
M21/C1	0.03	1.5	0.6	20	10	8

Mechanical properties of all weld metal

		Shielding gas	Condition	Yield strength (N/mm^2)	Tensile strength (N/mm^2)	Elongation (%)	Impact (ISO), J	
							+20°C	-20°C
Required	AWS A5.22			not required	min 520	min 35		
	ISO 17663			min 320	min 510	min 30		
Typical values after welding		M21/C1	AW	400	580	38	55	

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm) 1.2	1.6
Wire reel B202	5	X	
Plastic spool S300	12.5	X	X

Identification	Imprint: Cor-Revicod®308LT0

Cor-Revicod®308LT0: rev. EN 20

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Materials to be welded

Steel	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Low carbon steel	X2 CrNi 19 11		1.4306	(TP) 304L	S30403
C<0.03%				CF-3	J92500
	X2 CrNiN 18 10		1.4311	(TP) 304LN	S30453
				302, 304	S30400
Medium carbon steel	X4 CrNi 18 10		1.4301	(TP) 304	S30409
C>0.03%		GX5 CrNi 19 10	1.4308	CF 8	J92600
Ti-, Nb- stabilized	X6 CrNiTi 18 10		1.4541	(TP) 321	S32100
				(TP) 321H	S32109
	X6 CrNiNb 18 10		1.4550	(TP) 347	S34700
				(TP) 347H	S34709
		GX5 CrNiNb 19 10	1.4552	CF-8C	J92710

Welding parameters, optimum fill, Shielding gases M21/C1

Diameter (mm)	Current / Voltage	Welding position PA/1G	PB/2F	PC/2G	PF/3G up	PE/4G
1.2		100-250	100-250	100-200		
1.6		140-300	140-300	140-200		

Remarks/ Application advice

Use for positional welding: Cor-Revicod®308LT1