

MIG/MAG Cored Wires Stainless and Heat resistant steels

FLUXINOX 308L is an alloyed rutile flux cored wire for the welding of unstabilized and stabilized corrosion resistant Cr Ni-steels. Suitable for operating temperatures up to 350 °C, non-scaling up to approximately 800 °C. FLUXOFIL 308 L features outstanding, almost spatter-free, welding properties. Very easy slag removal from fillet welds. Flat and smooth weld beads without undercut.

Classification	
EN ISO	17633-A: T 19 9 L R C 3
EN ISO	17633-A: T 19 9 L R M 3
EN ISO	17633-B: TS308L-FB0
AWS	A5.22: E308LT0-1
AWS	A5.22: E308LT0-4

Approvals	Grade
DB	●
DNV	308L
GL	4550S
LRS	304LS
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Ferrite
≤ 0.04	1.7	0.6	20	10	6-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-20 °C	-196 °C
As Welded	≥ 350	≥ 520	≥ 35	≥ 40	≥ 27

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : C1, M21

Materials

AISI 304 - 304L - 302

1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



PA PB

Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	●
1.2	●