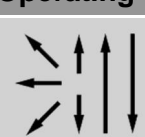


Classification						
EN ISO 17633-A		EN ISO 17633-B		AWS A5.22		
T 19 9 L P M/C 1		-		E308LT1-4/-1		
Characteristics and typical fields of application						
<p>Avesta FCW 308L/MVR-PW is designed for welding 1.4301/ASTM 304 type stainless steels. It is also suitable for welding steels that are stabilised with titanium or niobium, such as 1.4541/ASTM 321, 1.4878/321H and 1.4550/347 in cases where the construction will be operating at temperatures below 400°C. For higher temperatures a niobium stabilised consumable such as Avesta FCW- 2D 347/MVNB is required. Avesta FCW 308L/MVR-PW has a stronger arc and a faster freezing slag compared to the 2D type. It is designed for all-round welding and can be used in all positions without changing the parameter settings. Weldability is excellent in the vertical-up and overhead positions. Avesta FCW 308L/MVR Cryo should be welded using direct current positive polarity (DC+) with a recommended wire stick-out of 15 – 20 mm.</p> <p>Corrosion resistance:</p> <p>Corresponding to 1.4301/ASTM 304, i.e. very good under fairly severe conditions, e.g. in oxidising acids and cold or dilute reducing acids.</p>						
Base Materials						
Outokumpu	EN	ASTM	BS	NF	SS	
4301	1.4301	304	304S31	Z7 CN 18-09	2333	
4307	1.4307	304L	304S11	Z3 CN 18-10	2352	
4311	1.4311	304LN	304S61	Z3 CN 18-10 Az	2371	
4541	1.4541	321	321S31	Z6 CNT 18-10	2337	
Typical analysis of all-weld metal (wt.-%)						
	C	Si	Mn	Cr	Ni	
wt-%	0.025	0.7	1.4	19.7	10.2	
Mechanical properties of all-weld metal						
Heat-treat-ment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J		Hardness
	MPa	MPa	%	+20 °C	-196°C	HB
u	390	570	39	60	-	200
u untreated, as-welded – shielding gas Argon + 18 % CO ₂						
Operating data						
	Polarity DC (+)	shielding gases: Ar + 15 – 25% CO ₂ 100 % CO ₂	re-drying if necessary: 150°C / 24 hrs	amps A 125 – 280	voltage V 20 – 34	ø (mm) 1.2
Ar + 15 – 25% CO ₂ offers the best weldability, but 100% CO ₂ can be also used (voltage should be increased by 2V). Gas flow rate 20 – 25 l/min.						
Approvals						
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