

Classifications

EN ISO 17633-A	EN ISO 17633-B	AWS A5.22
T 19 9 L P M21 1	TS308L-F M21 (C1) 1	E308LT1-4
T 19 9 L P C1 1		E308LT1-1

Characteristics and typical fields of application

Rutile strip alloyed flux cored welding wire with fast freezing slag providing excellent positional operating characteristics and fast travel speeds. It is easy to use and operates with a powerful penetrating spray arc transfer, minimum spatter formation and self releasing slag.

This flux cored welding wire offers many economical and quality advantages over solid wire pulse arc welding. High deposition rates and productivity gains are easily achievable. Additional cost effective benefits are offered through use of less expensive shielding gases (Argon + 15 – 25 % CO₂ or 100 % CO₂), good wetting characteristics (less grinding), little temper discoloration & bead oxidation (less pickling expenses), easy operation and safe penetration (reduces the risk of weld defects and associated repair work costs), and smooth and clean weld finish (less post weld work).

Due to its characteristics mainly for positional welding and service temperatures between –196 °C to +350 °C. For down hand & horizontal welding positions (1G, 1F, 2F) our flux cored wire BÖHLER EAS 2-FD should be preferred.

Base materials

1.4306 X2CrNi19-11, 1.4301 X5CrNi18-10, 1.4311 X2CrNiN18-10, 1.4312 GX10CrNi18-8, 1.4541 X6CrNiTi18-10, 1.4546 X5CrNiNb18-10, 1.4550 X6CrNiNb18-10

AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 Gr. C9, A320 Gr. B8C or D

Typical analysis of all-weld metal (wt.-%)

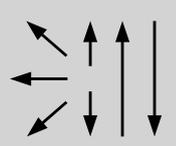
	C	Si	Mn	Cr	Ni
wt.-%	0.03	0.7	1.5	19.8	10.5

Mechanical properties of all-weld metal

Condition	Yield strength R _{p0,2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	–196 °C
u	380 (≥ 320)	560 (≥ 520)	40 (≥ 35)	70	40 (≥ 32)

u untreated, as welded – shielding gas Ar + 18 % CO₂

Operating data

	Polarity:	Shielding gases:	Redrying:	ø (mm)	Amps A	Voltage V
	DC (+)	Argon + 15 – 25 % CO ₂	possible 150 °C / 24 h	1.2	100 – 220	20 – 31
		100 % CO ₂		1.6	175 – 260	21 – 29

Welding with standard GMAW-facilities possible, slightly trailing torch position (angel appr. 80°), slight weaving is recommended for positional welding; when using 100 % CO₂ as shielding gas it is necessary to increase the voltage by 2 V; the gas flow should be 15 – 18 l/min

Approvals

TÜV (09117.), DB (43.014.23), CWB (E308LT1-1(4)), GL (4550S (C1,M21)), SEPROZ, CE