

Classification

AWS A5.22

E308LT1-1

Characteristics and typical fields of application

Avesta FC 308L-T1 is designed for welding austenitic stainless steel type 19Cr 10Ni or similar. This filler metal is also suitable for welding titanium and niobium stabilised steels such as ASTM 321 and ASTM 347 in case where the construction will be operating at temperatures below 400°C. For higher temperatures a niobium stabilised consumable such as Avesta 347/MVNB is required.

Avesta FC 308L-T1 provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and it is designed for all-round welding and can be used in all positions without changing parameter settings.

Base Materials

Outokumpu 4301, 4307, 4311, 4541; EN 1.4301, 1.4307, 1.4311, 1.4541; ASTM 304, 304L, 304LN, 321, 347; BS 304S31, 304S11, 304S61, 321S31; NF Z7 CN 18-09, Z3 CN 18-10, Z3 CN 18-10 Az, Z6 CNT 18-10; SS 2333, 2352, 2371, 2337.

Typical analysis of solid wire (wt.-%)

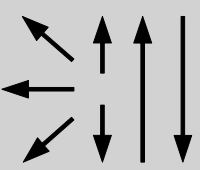
C	Si	Mn	Cr	Ni	Mo
0.02	0.70	1.30	19.2	10.2	0.01

Ferrite Number ≈ 3 – 10 FN WRC 92

Mechanical properties of all-weld metal

Heat treatment	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =4d ₀)	Impact work ISO-V KV J
	MPa	MPa	%	-20 °C
As Welded	390	570	39	60

Operating data

	Polarity DC+	Interpass temperature : Max. 150°C Heat Input: Max. 2.0 KJ/mm Shielding Gas : 100% CO ₂ Gas Flow rate: 20-25 L/min Wire stick out : 15-20 mm
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Approvals

ABS

Size, Packaging and Electrical Operating Data

Size mm	Kg / Spool	Amperage (A)	Voltage (V)
1.20	15.0	120 – 280	22 – 30