

# Weld FCW 308L, 309L & 316L

All-positional rutile flux cored wires for welding of stainless steels.

**Weld FCW 308L** : AWS A5.22 E308LT1-1

**Weld FCW 309L** : AWS A5.22 E309LT1-1

**Weld FCW 316L** : AWS A5.22 E316LT1-1

**Welding Current** : DC+

**Shielding Gas** : 100% CO<sub>2</sub>



## Description

Weld FCW 308L, 309L & 316L are all-positional rutile type flux cored wires for joining stainless steels of similar composition. Weld FCW 309L is suitable for dissimilar joining with unalloyed or low alloyed steels. These wires provide smooth running characteristics with a good slag release and weld bead appearance.

## Typical All Weld Metal Properties

Properties	Weld FCW 308L	Weld FCW 309L	Weld FCW 316L
C	0.03	0.03	0.03
Mn	1.40	1.10	1.10
Si	0.50	0.60	0.60
Cr	19.50	23.80	19.00
Ni	9.50	12.50	12.30
Mo			2.50
UTS (MPa)	550	550	560
Elongation (%)	40	35	40

## Applications

- General Stainless Steel Fabrication
- Architectural
- Dissimilar Metals Joining

## Features

- Smooth running characteristics
- Good weld bead appearance
- All position welding

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