



MIGINOX FC 308L

FCAW STAINLESS STEEL

AWS A/SFA 5.22 **E308LT1-1/4**

CLASSIFICATION:

EN ISO 17633-A

T 19 9 L P C1 2

T 19 9 LP M21 2

KEY FEATURES:

- Rutile based extra low carbon gas shielded stainless steel FCAW wire
- Typical 19Cr-10Ni weld deposit
- Stable arc, low spatter and easy slag removal
- Excellent bead appearance
- Excellent crack resistance and corrosion resistance
- Radiographic weld quality

APPROVALS: RDSO Class VI/CE

TYPICAL APPLICATIONS:

- Welding of 18Cr-8Ni stainless steels of AISI 301, 302, 304, 304L type
- Application in Chemical, Food processing industries, Pipes & tubes

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Cr	Ni	Mo
0.04 max	0.50-2.50	1.0 max	18.0-21.0	9.0-11.0	0.5 max

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

With mixed gas chemical composition and mechanical properties will be higher.

PARAMETERS - PACKING DATA:

Ø , mm	Kg/Spool		
1.2	12.5	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions, Except Vertical Down: 
1.6	12.5		

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20
80Ar+20CO ₂	18-25