



**FCAW STAINLESS STEEL**  
**MIGINOX FC 308L**

GAS SHIELD FLUX CORED WIRE FOR EXTRA LOW CARBON 19/9 TYPE STAINLESS STEEL



**CLASSIFICATION :** AWS A/SFA 5.22    EN ISO 17633-A    **APPROVALS:**

E308LT1-1/4    T 19 9 L R C/M 2    RDSO Class VI

**KEY FEATURES :**

- Rutile based extra low carbon gas shielded stainless steel FCW 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

**WELDING POSITION :**



**DCEP**

| Shielding Gas          | Gas Flow Rate, LPM | Stickout, mm |
|------------------------|--------------------|--------------|
| CO <sub>2</sub>        | 10-20              | 10-20        |
| 80Ar+20CO <sub>2</sub> | 18-25              | 10-20        |

**TYPICAL APPLICATIONS :**

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

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :**

|               | C        | Mn        | Si      | Cr        | Ni       | Mo      | S        | P        |
|---------------|----------|-----------|---------|-----------|----------|---------|----------|----------|
| Specification | 0.04 max | 0.50-2.50 | 1.0 max | 18.0-21.0 | 9.0-11.0 | 0.5 max | 0.03 max | 0.04 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 | Voltage, V | Amperage, A | Kg/Spool |
|-------|------------|-------------|----------|
| 1.2   | 22 - 30    | 120 - 300   | 12.5     |
| 1.6   | 24 - 32    | 200 - 360   | 12.5     |

**EQUIVALENT :**

SMAW Electrode: **Superinox 1C**

GMAW Wire: **Miginox 308L**

GTAW Wire: **Tiginox 308L**