

ROYAL PRIME-308L

STAINLESS STEEL FLUX-CORED WELDING WIRE
FOR WELDING 18/8 STEEL

BASIC ALLOY: FE, MN, CR, NI
AWS/SFA-5.22: E308L T 1/4
EN ISO 17633-A : T 19 9 L P C1 2

KEY FEATURES:

ROFIL-308L wire for 18%Cr - 8%Ni stainless steel, For all-position welding. Austenitic structure weld metal, smooth and stable arc, low spatter loss and easy slag remove. Low carbon content in weld metal to get good crack and inter-granular corrosion resistance. Good bead appearance, easy to get smooth fillet size,

APPLICATIONS

- For welding types 301, 302, 304, 304L, 308 and 308L of stainless steel.
- May be used for welding types 321 and 347 if service temperature does not exceed 500°F(260°C).

SHEILDING GAS

- Welding with CO2 gas and Ar+ CO2 gas mixture

CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni	Cr	Mo
0.030 Max.	0.50-2.50	1.00max.	0.030 Max	9.00-11.00	18.00-21.00	0.17 max.

MECHANICAL PROPERTIES

UTS (N/mm2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT	Ferrite Content
490 Min.	35 Min.	- 30C : 27 J min.	4-10 FN

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Spool packing 12.5 kg.	Spool packing 15kg
1.20	3/ 64"	120-300	18-22	✓	✓
1.40	1/ 18"	160-340	18-22	✓	✓
1.60	1/ 16"	180-360	18-22	✓	✓
2.00	5/64"	200-380	18-22	✓	✓

- offshore oil rig
- bridges