

NST A-308L

AWS: A5.22-95: E308LT 1-4
 NS EN ISO 17633-A: T 19 9 L P M 1
 EN ISO 9606-1: FM5



Flux cored wire for positional welding of corrosion resistant materials such as AISI 304, EN 1.4301 etc.

General description:

NST A-308L is a rutile flux cored wire for positional welding of corrosion resistant materials such as AISI 304 etc.
 The flux cored wire uses an Argon/CO₂ mixed shielding gas.
 This ensures a user friendly and stable welding arc, less spatter, good visual bead appearance and smooth transition to the parent materials.
 The newly developed slag system gives the welder better control of the weld pool and this wire can now be welded without weaving in all positions

It is also suitable for use with ceramic backing for single sided welding.

Welding positions:



Welding current:

DC+

Gas flow:

15-23 l/min.

Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	
0.024	0.60	1.38	0.020	0.003	0.05	9.79	20.44	0.02	

Shielding gas:

Argon+ 18-25% CO₂.

Typical mechanical properties of all-weld-metal:

Yield and Tensile Strengths				
Yield Mpa(Rp0.2)	Tensile Mpa(Rm)	Elongation %		
415	603	38		

Guidance - Ampere (DC+):

Electrode diameter			
Ampere / Volt			

Packaging information:

1,2mm x 5,0kg D200
 1,2mm x 12,5kg D300

Approvals:

CE

Reference / date:

NST A-308L,
 English, 06.02.2018.