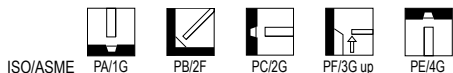


**Cor-A-Rosta® P304L****CLASSIFICATION**

AWS A5.22 : E308LT1-1/4  
 ISO 17663-A : T 19 9 L P C/M 2

**GENERAL DESCRIPTION**

Gas shielded flux cored stainless steel wire electrode for positional welding  
 Stable arc, low spatter and good slag removal  
 Excellent wire feeding and operator appeal  
 Bright appearance of weld metal

**WELDING POSITIONS****CURRENT TYPE**

DC +  
 M21 : Mixed gas Ar+ (>15-25%) CO<sub>2</sub>  
 C1 : Active gas 100% CO<sub>2</sub>  
 Amount : 15-25 l/min

**APPROVALS**

Shielding gas	DNV	GL	TÜV
M21	308LMS	4550S	+
C1			pending

**CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL**

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc.WRC 192)
M21 /C1	0.03	1.3	0.7	19.5	10	8

**MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL**

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)	
						+20°C	-110°C
Required: AWS A5.22 ISO 17663-A Typical values	M21/C1	AW	not required min. 320 400	min.520 min. 510 560	min. 35 min. 30 42	80	40

**PACKAGING AND AVAILABLE SIZES**

Diameter (mm)	1.2
Unit : 15 kg spool S300	X

**Cor-A-Rosta® P304L****MATERIALS TO BE WELDED**

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
<b>Extra low carbon (C &lt;0.03%)</b>					
	X2 CrNi 19 11		1.4306	(TP)304L CF-3	S30403 J92500
	X2 CrNiN 18 10		1.4311	(TP)304LN 302,304	S30453 S30400
<b>Medium carbon (C &gt;0.03%)</b>					
	X4 CrNi 18 10		1.4301	(TP)304	S30409
		GX5 CrNi 19 10	1.4308	CF 8	J92600
<b>Ti-, Nb stabilized</b>					
	X6 CrNiTi 18 10		1.4541	(TP)321 (TP)321H	S32100 S32109
	X6 CrNiNb 18 10		1.4550	(TP)347 (TP)347H	S34700 S34709
		GX5 CrNiNb 19 10	1.4552	CF-8C	J92710

**WELDING PARAMETERS, OPTIMUM FILL PASSES**

Diameter (mm)	Welding positions			
	PA/1G	PB/2F	PC/2G	PF/3G up
1.2	100-250A	100-250A	100-200A	100-180A

**REMARKS/APPLICATION ADVICE**

For downhand welding, use Cor-A-Rosta 304L