

INOXCORED 308L V

MIG/MAG Cored Wires

Stainless and Heat resistant steels

INOXCORED 308L V is an alloyed rutile flux cored wire with a fast-freezing slag for the welding of unstabilized and stabilized corrosion resistant Cr Ni-steels. Suitable for operating temperatures up to 350 °C, non-scaling up to approximately 800 °C. INOXCORED 308L V exhibits outstanding, almost spatter-free, welding properties with very easy slag removal from fillet welds resulting in flat and smooth weld beads without undercut into the base metal. Due to only slight discolouration of the weld beads, pickling costs can be minimised. Due to the fast-freezing slag of INOXCORED 308L V, it is well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.



Classification	
EN ISO	17633-A: T 19 9 L P C 1
EN ISO	17633-A: T 19 9 L P M 1
EN ISO	17633-B: TS308L-FB1
AWS	A5.22: E308LT1-1
AWS	A5.22: E308LT1-4

Approvals			
DB	DNV	LRS	TÜV
●	308L	304LS	●

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Ni	Ferrite
All weld metal	≤ 0.04	< 1.4	0.6	20	10	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation	Impact Energy ISO - V (J)	
				-20 °C	-196 °C
As Welded	≥ 320	≥ 520	≥ 35	≥ 40	≥ 27

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : C1, M21

Materials

AISI 304 - 304L - 302

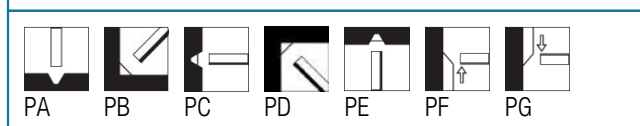
1.4541 (X6CrNiTi18-10); 1.4301 (X4CrNi18-10); 1.4311 (X2CrNiN18-10)

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



INOXCORED 309L V

MIG/MAG Cored Wires

Stainless and Heat resistant steels

INOXCORED 309L V is an alloyed rutile flux cored wire for joining high-alloyed Cr and Cr-Ni-(Mo) steels to unalloyed steels, as well as for depositing austenitic stainless cladding. The highest operating temperature for dissimilar joints is 300 °C. The weld metal is non-scaling up to 850 °C. Preheating and interpass temperatures should be calculated according to the base metal used. INOXCORED 309L V exhibits outstanding, almost spatter-free, welding properties and produces finely rippled flat and smooth welds which are free of undercut. Very easy slag removal. Due to its fast-freezing slag, INOXCORED 309L V is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.



Classification

EN ISO	17633-A: T 23 12 L P C 1
EN ISO	17633-A: T 23 12 L P M 1
EN ISO	17633-B: TS309L-FB1
AWS	A5.22: E309LT1-1
AWS	A5.22: E309LT1-4

Approvals

DB	DNV	GL	LRS	RINA	TÜV
●	309L	4332S	SS/CMn	309LS	●

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Ni	Ferrite
All weld metal	≤ 0.04	1.5	0.6	24	13	12-20

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation	Impact Energy ISO - V (J)	
				20 °C	-60 °C
As Welded	≥ 320	≥ 520	≥ 30	≥ 40	≥ 27

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : C1, M21

Materials

A312 TP309S; carbon steel to stainless steels joint

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



INOXCORED 316L V

MIG/MAG Cored Wires

Stainless and Heat resistant steels

INOXCORED 316L V is a rutile flux cored wire with a fast-freezing slag suitable for the welding of unstabilized and stabilized corrosion resistant CrNiMo steels. The weld metal is resistant to intergranular corrosion up to 400°C, and non-scaling up to 800°C. INOXCORED 316L V exhibits outstanding, almost spatter-free, welding properties with very easy slag removal from fillet welds, even in acute angles. The weld beads produced are finely rippled without undercut. Due to only slight discolouration of the welds, pickling costs can be minimised. Due to its fast-freezing slag, INOXCORED 316L V is used for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions.



Classification	
EN ISO	17633-A: T 19 12 3 L P C 1
EN ISO	17633-A:T 19 12 3 L P M 1
EN ISO	17633-B: TS316L-FB1
AWS	A5.22: E316LT1-1
AWS	A5.22: E316LT1-4

Approvals		
DNV	LRS	TÜV
316L	316L S	●

CE

Chemical analysis (Typical values in %)

	C	Mn	Si	Cr	Ni	Mo	Ferrite
All weld metal	≤ 0.04	1.5	0.6	19	12	2.8	5-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				20 °C	-110 °C
As Welded	≥ 320	≥ 510	≥ 30	≥ 47	≥ 27

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : C1, M21

Materials

1.4401 (X4CrNiMo17-12-2), 1.4435 (X2CrNiMo18-14-3)

1.4571 (X6CrNiMoTi17-12-2), 1.4583 (X10CrNiMoNb18-12)

AISI 316L

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+

