

MIG/MAG Cored Wires Stainless and Heat resistant steels

FLUXINOX 308L-PF 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. FLUXINOX 308L-PF 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 FLUXINOX 308L-PF, 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	Grade
DNV	308L
LRS	304LS
TÜV	●

CE

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Ferrite
≤ 0.04	1.4	0.6	20	10	6-10

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation	Impact Energy ISO - V (J)	
				-20 °C	-196 °C
As Welded	≥ 350	≥ 520	≥ 35	≥ 40	≥ 27

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : C1, M21

Materials

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

AISI 304 - 304L - 302

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

Packaging Type	BS300
Diam(mm) / weight(kg)	15
1.0	●
1.2	●