

Cor-A-Rosta 304L

Stainless rutile cored wire

Classification

AWS A5.22-95 : E308LT0-1/-4
EN 12073-99 : T 19 9 L R C/M 3

General description

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

Welding positions



ISO/ASME PA/1G PB/2F

Current type/Shielding gas

DC +
Ar+ (>5-25%) CO₂ (EN 439: M21)
100% CO₂ (EN 439: C1)
15-25 l/min

Approvals

Shielding gas	DNV	GL	LR	TÜV
M21	308LMS	4550S		+
C1	308LMS		304L	+

Chemical composition (w%) and Ferrite Number (FN), typical, all weld metal

Shielding gas	C	Mn	Si	Cr	Ni	FN
M21/C1	0.03	1.5	0.6	20	10	8

Mechanical properties, typical, all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J) -20°C
Required:	AWS A5.22-95 EN 12073-99		not required min. 320	min. 520 min. 510	min. 35 min. 30	
Typical values	M21/C1	AW	400	580	38	55

Packaging and available sizes

Unit	Net weight (kg)	Size (mm)	
		1.2	1.6
Wire reel B202	5	X	
Plastic spool S300	12.5	X	X

Cor-A-Rosta 304L: rev. EN 15

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Materials to be welded

Steel grades	EN 10088-11-2	EN 102 13-4	W.Nr.	ASTM/ACI A240/A312/A351	UNS
Extra low carbon C <0.03%	X2 CrNi 19 11		1.4306	(TP)304L CF-3	S30403 J92500
	X2 CrNiN 18 10		1.4311	(TP)304LN 302.304	S30453 S30400
Medium carbon C >0.03%	X4 CrNi 18 10		1.4301	(TP)304 CF 8	S30409 J92600
		GX5 CrNi 19 10	1.4308	(TP)304 CF 8	S30409 J92600
Ti-, Nb- stabilized	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 in shielding gas M21/C1

Welding position Diameter (mm)	PA/1G Current (A)	PB/2F	PC/2G
1.2	100-250	100-250	100-200
1.6	140-300	140-300	140-200

Remarks/ Application advice

Use for positional welding: Cor-A-Rosta P304L