

# Cor-A-Rosta P304L

## Stainless steel rutile cored wire

### 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/Shielding gas (ISO 14175)

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

### Packaging and available sizes

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

Cor-A-Rosta P304L: rev. EN 23

**Liability:** All information in this data sheet is based on the best available knowledge, is subject to change without notice and can only be considered as suitable for general guidance **Fumes:** Consult information on Welding Safety Sheet, available upon request

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## 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 in shielding gas M21/C1

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

Use for downhand welding: Cor-A-Rosta 304L