

*Flux Cored Wires for Welding  
of Stainless Steels*



**FLUXINOX**

[www.oerlikon-welding.com](http://www.oerlikon-welding.com)

## CORED WIRES FOR STAINLESS STEELS

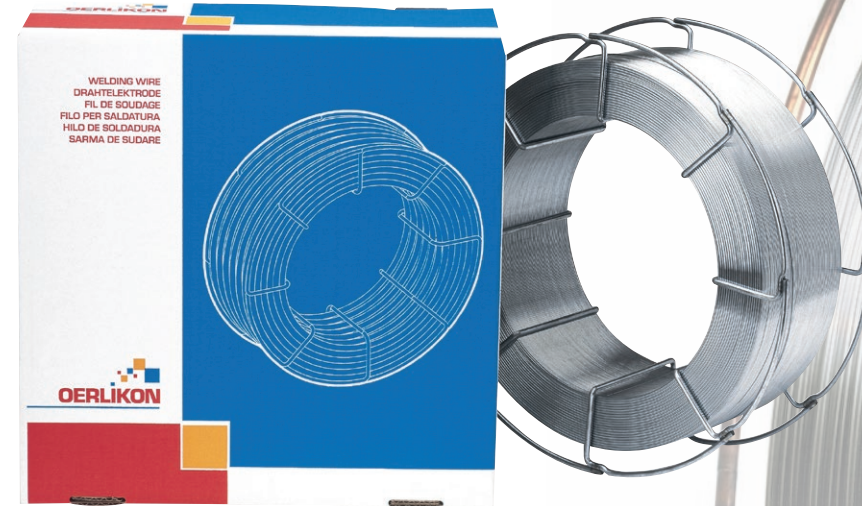


For CO<sub>2</sub> and AR/CO<sub>2</sub> shielding gases:

- FLUXINOX 308L
- FLUXINOX 308L PF
- FLUXINOX 347L
- FLUXINOX 316L
- FLUXINOX 316L PF
- FLUXINOX 309L
- FLUXINOX 309L PF
- FLUXINOX 309MoL

## FLUXINOX

- The best quality of welds with standard CV power sources helps to reduce investment expenditures.
- Application of standard Ar/CO<sub>2</sub> or CO<sub>2</sub> shielding gases optimizes welding cost.
- Optimal semiautomatic process for positional welding, high productivity reduces labor and total welding costs.
- Reduced spatter, better performance and weldability comparing to solid wires.
- Welds with high corrosion resistance due to low carbon and balanced chemical composition.
- Spatter free welds with easy slag removal.
- Flat and smooth bead profile.
- Pickling cost minimized due to only slight discoloration.



### AUSTENITIC STAINLESS STEELS

FLUXINOX	GAS	AWS 5.22	EN ISO 17633-A
<b>308L</b>	M21/C1	E308LT0-1/4	T 19 9 L R M/C 3
<b>308L PF</b>	M21/C1	E308LT1-1/4	T 19 9 L R M/C 1
<b>316L</b>	M21/C1	E316LT0-1/4	T 19 12 3 L R M/C 3
<b>316L PF</b>	M21/C1	E316LT1/4	T 19 12 3 L R M 1
DISSIMILAR WELDS/BUFFER/SURFACING/STABILIZED			
FLUXINOX	GAS	AWS 5.22	EN ISO 17633-A
<b>307L</b>	M21/C1		T 18 8 Mn R M/C 3
<b>347</b>	M21/C1	E347T0-1/4	T 19 9 Nb R M/C 3
<b>309L</b>	M21/C1	E309LT0-1/4	T 23 12 L P M/C 3
<b>309L PF</b>	M21/C1	E309LT1-1/4	T 23 12 L P M/C 1
<b>309MoL</b>	M21/C1	E309LMoT0-1/4	T 23 12 2 L R M/C 3





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