

CLEAROSTA F 304L

TOP FEATURES

- Reduced exposure of welders to welding fumes.
- High alloyed rutile flux cored wire with fast freezing slag for the welding of 308 corrosion resistant Cr Ni-steels.
- Bright appearance of weld metal
- Reduced welding fume (up to -40%).
- Reduced emission of hexavalent Cr content (up to -60%).
- Easy slag removal.

TYPICAL APPLICATIONS

- Steel construction
- Shipbuilding
- General fabrication

CLASSIFICATION

AWS A5.22 E308LT1-1 / E308LT1-4
EN ISO 17633-A T 19 9 L P C 1/M 1

CURRENT TYPE

DC+

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ (>15-25%) CO₂
C1 Active gas 100% CO₂
Gas flow 15-25 l/min

APPROVALS

LR	BV	TÜV
+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	Cr	Ni	FN (acc.WRC 1992)
M21/C1	0.03	1.3	0.7	19.5	10	3-12

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)
						-20°C -196°C
Typical values	M21/C1	AW	≥350	≥520	≥35	≥40 ≥27

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (BS300)	15.0	710013

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.

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