

selectarc  **FC 308L, 309L and 316L CC+** **STAINLESS STEEL**

DESCRIPTION

A full line of **gas shielded** all position or flat and horizontal position, stainless steel, **flux-cored wire with slag, conforms to AWS A5.22 specifications**, for welding a wide range of stainless steel grades (301, 302, 304, 304L, 308, 308L, 309, 309L, 316, 316L, 317, 317L, 318, 321, 347, etc.)

AP= "All position" wires : FC 308L-AP, FC 309L-AP et FC 316L-AP = AWS A5.22 : E3XXLT1-1/4
 FP= "Flat and horizontal" wires : FC 308L-FP, FC 309L-FP et FC 316L-FP = AWS A5.22 : E3XXLT0-1/4

CHARACTERISTICS

- Excellent weldability characteristics
- Stable arc with low spatter
- High deposit rate and easy slag removal
- Low carbon filler metal
- Excellent on DC+ power supply

MECHANICAL PROPERTIES

Selectarc FC 308L : Tensile strength = 90 200 psi (620 MPa) ; Elongation = 36 %
 Selectarc FC 309L : Tensile strength = 84 400 psi (580 MPa) ; Elongation = 35 %
 Selectarc FC 316L : Tensile strength = 87 300 psi (600 MPa) ; Elongation = 32 %

WELDING SPECIFICATIONS

Selectarc FC 308L = welding of stainless steel grades 301, 302, 304L, 308, 308L, 321 and 347
 Selectarc FC 309L = welding of stainless steel grades 309, 309L, 304, 304L, 308 and 308L
 Selectarc FC 316L = welding of stainless steel grades 316, 316L, 317, 317L and 318

WELDING PARAMETRES

Gas : 100 % CO₂ or Ar - CO₂ mixture
 Packaging : 15 kg spool

	AP version – All position			FP version : Flat and horizontal		
	0.9 mm .035"	1.2 mm .045"	1.6 mm 1/16"	0.9 mm .035"	1.2 mm .045"	1.6 mm 1/16"
Amperage	100 - 180 A	130 - 270 A	150 - 400 A	80 - 180 A	100 - 270 A	150 - 400 A
Voltage	20 - 30 V	22 - 35 V	23 - 37 V	18 - 28 V	23 - 35 V	23 - 37 V
Stick-out	1/2"	1/2" - 1	1/2" - 1	1/2"	1/2" - 1	1/2" - 1
Gas (pch)	35 - 45	40 - 50	40 - 50	35 - 45	40 - 50	40 - 50

Complete range of stainless steel electrodes certified CWB

TIG rods certified CWB : Selectarc TIG 308L, Selectarc TIG 309L and Selectarc TIG 316L

MIG solid wires certified CWB : Selectarc MIG 308LSi, Selectarc MIG 309LSi and Selectarc MIG 316LSi

Other stainless steel grades available on request.

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Specialized welding alloys and technology. For technical assistance or for ordering:



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