

Classifications					
DIN 8555			ASME IIC SFA 5.22		
MF 9-GF-150-C			E 308L-T3		
Characteristics					
Self shielded flux cored wire depositing a 19 % Chromium, 9 % Nickel, low Carbon stainless steel alloy.					
Microstructure:	Austenite + / – 10 % ferrite				
Machinability:	Good				
Oxy-acetylene cutting:	Cannot be flame cut				
Deposit thickness:	No restriction				
Field of use					
Cladding stainless steels containing 16 – 21 % Cr and 8 – 13 % Ni on un- or low alloyed carbon steels.					
Typical analysis in %					
C	Mn	Si	Cr	Ni	Fe
0.02	0.8	0.9	20.0	9.5	balance
Typical mechanical properties					
Hardness as welded: 170 HB					
Recommended welding parameters					
Wire diameter [mm]	Amperage [A]		Voltage [V]		Stick-Out [mm]
1.2	120 – 150		26 – 30		35 – 40
1.6	180 – 220		26 – 30		35 – 40