

Cor-A-Rosta® P304L

CLASSIFICATION

AWS A5.22	E308LT1-1/-4	A-Nr	8	Mat-Nr	1.4316
ISO 17633-A	T 19 9 L P C/M 2	F-Nr	6		
		9606 FM	5		

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 (ISO/ASME)



CURRENT TYPE / SHIELDING GAS (ISO 14175)

DC +
 M21 : Mixed gas Ar+ (>15-25%) CO₂
 C1 : Active gas 100% CO₂
 Flow rate: 15-25 l/min

APPROVALS

Shielding gas	TÜV
M21	+

CHEMICAL COMPOSITION (W%), 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	8

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength [N/mm ²]	Tensile strength [N/mm ²]	Elongation [%]	Impact ISO-V(J)	
						+20°C	-110°C
Required: AWS A5.22 ISO 17633-A Typical values	M21/C1	AW	not required min. 320 400	min.520 min. 510 560	min. 35 min. 30 42	80	40

PACKAGING AND AVAILABLE SIZES

Diameter [mm]	1.2
15 kg spool S300	X

Cor-A-Rosta® P304L : rev.C-EN26-19/05/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
 Fumes: Safety Data Sheets (SDS) are available on our website.

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades	EN 10088-1/-2	EN 10213-4	Mat. Nr	ASTM/ACI A240/A312/A351	UNS
Extra low carbon [C <0.03%]					
	X2CrNi19-11		1.4306	[TP]304L CF-3	S30403 J92500
	X2CrNi18-10		1.4311	[TP]304LN 302,304	S30453 S30400
Medium carbon [C >0.03%]					
	X4CrNi18-10		1.4301	[TP]304	S30409
		G-X5CrNi19-10	1.4308	CF 8	J92600
Ti-, Nb stabilized					
	X6CrNiTi18-10		1.4541	[TP]321 [TP]321H	S32100 S32109
	X6CrNiNb18-10		1.4550	[TP]347 [TP]347H	S34700 S34709
		G-X5CrNiNb19-10	1.4552	CF-8C	J92710

WELDING PARAMETERS, OPTIMUM FILL PASSES

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

For downhand welding, use Cor-A-Rosta 304L