



DESCRIPTION

Gas shielded flux-cored wire with slag (FCAW), conforms to AWS A5.22 specifications and certified by CWB (Canadian Welding Bureau), for all position welding of a wide range of stainless steel grades.

CHARACTERISTICS

- Certified by CWB to CSA W48
- Conforms to specifications : AWS A5.22 and ASME SFA 5.22 : E3XXLT1-1/4
- Excellent weldability characteristics
- Stable arc with low spatter
- High deposit rate and easy slag removal
- Low carbon filler metal

MECHANICAL PROPERTIES (with CO₂ shielding gas)

Selectarc FC 308L-AP : Tensile strength = 83 000 psi (572 MPa) ; Elongation = 38 %

Selectarc FC 309L-AP : Tensile strength = 85 100 psi (587 MPa) ; Elongation = 38 %

Selectarc FC 316L-AP : Tensile strength = 81 000 psi (558 MPa) ; Elongation = 39 %

Strength levels will be slightly higher with an Ar + 20-25 % CO₂ mixture.

WELDING SPECIFICATIONS

Selectarc FC 308L-AP = welding of stainless steel grades 301, 302, 304L, 308, 308L, 321 and 347

Selectarc FC 309L-AP = welding of stainless steel grades 309, 309L, 304, 304L, 308 and 308L

Selectarc FC 316L-AP = welding of stainless steel grades 316, 316L, 317, 317L and 318

WELDING PARAMETRES

Gas : 100 % CO₂ or Ar + 20-25 % CO₂ mixture

Diameter :	0.9 mm .035"	1.2 mm .045"	1.6 mm 1/16"
Amperage	110 - 175	130 - 270	170 - 305
Voltage	23 - 28	22 - 34	23 - 29
Stick-out	5/8" à 3/4"	5/8" à 3/4"	3/4" à 1"
Gas (pch)	35 - 45	35 - 45	35 - 45

Also available in flux-cored wire for welding in flat and horizontal position (**Selectarc FC 3XXL-FP**) and metal-cored wire (MCAW) without slag (**Selectarc MC 3XXL**).

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: