Lincoln Electric Europe

Cor-A-Rosta™
stainless steel flux-cored wires

PRODUCT FEATURES

- ✔ Improved impact properties
- ✔ Higher deposition rate
- ✔ Extended approvals range
- ✔ Durable packaging

THE PACKAGING

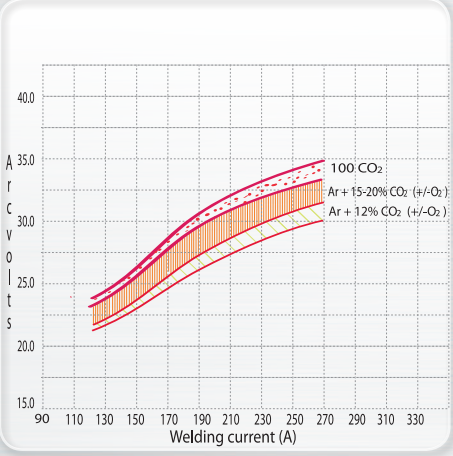
Cor-A-Rosta wires are packed into a hermetically sealed vacuum aluminium bag in order to provide an absolute protection against moisture pick-up.

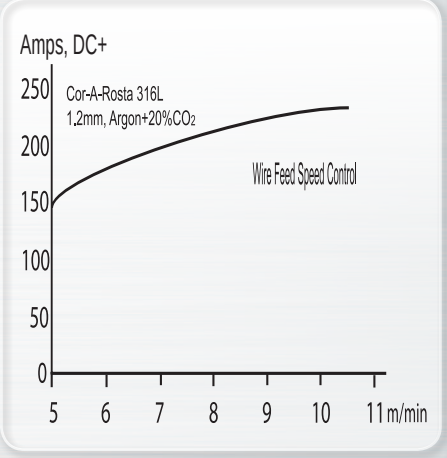
The S300 plastic spool type is used instead of the basket spool. Doing so, the risk of having the aluminium bag being punched during heavy duty transportation conditions is reduced.

BEST IN CLASS STAINLESS STEEL FLUX-CORED WIRES

Lincoln Electric has redeveloped its Cor-A-Rosta product range in order to supply the **best in class stainless steel flux cored wires** to the market. Improvements have been done in all areas: mechanical properties have been improved, deposition rates at a given intensity have been increased, the packaging has been optimized and the approval range has been extended to better satisfy our customers.

WELDING PARAMETERS GUIDE





	Cor-A-Rosta 3xxxL, dia. 1.2mm			Cor-A-Rosta P3xxxL, dia. 1.2mm		
	U (V)	WFS (m/min)	I (A)	U (V)	WFS (m/min)	I (A)
1G	28	7.5-8.5	180	30	7.5-8.5	180
2F						
3G				25	5.0-6.0	150
4G						

EASY TO UNDERSTAND RANGE

The purpose of a Cor-a-Rosta wire is easy to understand thanks to its name. Indeed, the product name contains either the well-known ASTM classification of the base material to be welded (such as Cor-A-Rosta 304L) or the AWS classification of the wire itself (such as Cor-A-Rosta 309L).

Furthermore, the recommended welding positions for these wires are also easily identified by their name. Thus:

Cor-A Rosta 304L: No special indication = downhand position

Cor-A-Rosta P304L: P stands for Position welding

This can avoid confusion and mistakes for the welders.

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TYPE AND SPECIFICATIONS

Product name	Shielding gas	Approvals						Item numbers	Dia. (mm)	Spool type/net weight	
	ISO 14175	BV	ABS	DNV	GL	LR	TüV			S200 / 5kg	S300 / 15kg
Cor-A-Rosta 304L	C1			X		X	X	585155	1.2		■
								585186	1.2	■	
	M21			X	X		X	585162	1.6		■
Cor-A-Rosta P304L	C1						X	585179	1.2		■
	M21				X		X				
Cor-A-Rosta 316L	C1	X		X		X	X	585308	1.2		■
	M21	X		X	X	X	X	585315	1.6		■
Cor-A-Rosta P316L	C1			X			X	585353	1.2	■	
	M21		X	X	X	X	X	585322	1.2		■
Cor-A-Rosta 309L	C1	X		X		X	X	585209	1.2		■
								585292	1.2	■	
	M21	X		X	X	X	X	585216	1.6		■
Cor-A-Rosta P309L	C1			X			X	585223	1.2		■
	M21		X	X	X	X	X	585285	1.2	■	
Cor-A-Rosta 309MoL	C1	X		X			X	585254	1.2		■
	M21			X		X	X	585261	1.6		■
Cor-A-Rosta P309MoL	C1							585247	1.2		■
	M21	X		X		X					
Cor-A-Rosta 4462	M21			X			X	585520	1.2		■
Cor-A-Rosta P4462	M21			X				585506	1.2		■

WIRE GRADES, CLASSIFICATIONS, CHEMICAL COMPOSITIONS AND MECHANICAL PROPERTIES

Product name	Shielding gas	Classifications		Dia. (mm)	Chemical composition % (deposit typical value)									Mechanical properties (all weld metal, typical values, AW condition)							
	ISO 14175	AWS A5.22	ISO17663		C	Mn	Si	Cr	Ni	Mo	Nb	N	FN	Re (MPa)	Rm (MPa)	A5 (%)	Impact ISO-V(J) +20°C	-20°C	-50°C	-75°C	-110°C
Cor-A-Rosta 304L	C1	E308LT0-1	T 19 9 L R C 3	1.2 - 1.6	0.03	1.3	0.6	20	10				8	400	555	42	75				40
	M21	E308LT0-4	T 19 9 L R M 3																		
Cor-A-Rosta P304L	C1	E308LT1-1	T 19 9 L P C 2	1.2	0.03	1.3	0.6	19.5	10				8	390	560	42	75				40
	M21	E308LT1-4	T 19 9 L P M 2																		
Cor-A-Rosta 316L	C1	E316LT0-1	T 19 12 3 L R C 3	1.2 - 1.6	0.03	1.4	0.6	19	12	2.7			9	440	570	39	70				35
	M21	E316LT0-4	T 19 12 3 L R M 3																		
Cor-A-Rosta P316L	C1	E316LT1-1	T 19 12 3 L P C 2	1.2	0.03	1.3	0.6	19	12	2.8			8	440	570	39	70				35
	M21	E316LT1-4	T 19 12 3 L P M 2																		
Cor-A-Rosta 347	M21	E347T0-4	T 19 9 Nb R M 3	1.2	0.03	1.2	0.45	19	10.5		0.5		8	440	610	41	85				
Cor-A-Rosta 309L	C1	E309LT0-1	T 23 12 L R C 3	1.2 - 1.6	0.03	1.4	0.6	24	12.5				15	450	570	36	45	40			
	M21	E309LT0-4	T 23 12 L R M 3																		
Cor-A-Rosta P309L	C1	E309LT1-1	T 23 12 L P C 2	1.2	0.03	1.2	0.6	23.3	12.6				15	440	565	37	60	55			
	M21	E309LT1-4	T 23 12 L P M 2																		
Cor-A-Rosta 309MoL	C1	E309LMoT0-1	T 23 12 2 L R C 3	1.2 - 1.6	0.03	1.3	0.6	23	12.8	2.3			20	545	695	29	50				
	M21	E309LMoT0-4	T 23 12 2 L R M 3																		
Cor-A-Rosta P309MoL	C1	E309LMoT1-1	T 23 12 2 L P C 2	1.2	0.03	0.8	0.6	22.7	12.5	2.3			20	525	675	34		45			
	M21	E309LMoT1-4	T 23 12 2 L P M 2																		
Cor-A-Rosta 4462	M21	E2209T0-4	T 22 9 3 N L R M 3	1.2	0.03	1.2	0.6	23	9.3	3.1		0.13	40	635	805	29		38	30		
Cor-A-Rosta P4462	C1	E2209T1-1	T 22 9 3 N L P C 2	1.2	0.03	1.2	0.6	23	9.2	3.1		0.13	40	640	790	29		60	55	30	
	M21	T2209T1-4	T 22 9 3 N L P M 2																		

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