



**PRIME 308LN**  
**PRIME 309LN**  
**PRIME 316LN**

**Self-Shielded**  
Stainless Steel Flux Cored Wire

Classifications:  
AWS 5.22 E308LT0-3  
AWS 5.22 E309LT0-3  
AWS 5.22 E316LT0-3

Welding Positions:



### Characteristics:

**PRIME 308LN / 309LN / 316LN** is a self-shielded, rutile-type flux-cored wire that supports flat-position welding without the need for shielding gas. It provides the same functionality as conventional 308L/309L/316L wires.

### Typical Applications:

It is mainly used for welding thin plate base materials, making it ideal for applications such as house repairs and outdoor welding in locations like islands, deserts, or other areas where gas cylinders are not easily accessible. It also serves as an alternative to smaller-sized stainless steel welding electrodes.

### Chemical Properties of Weld Metal (Wt%)

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
<b>PRIME 308LN</b>	0.018	1.26	0.55	0.012	0.009	9.95	20.21	0.02	0.03
<b>PRIME 309LN</b>	0.022	1.45	0.45	0.012	0.009	13.50	23.45	0.03	0.02
<b>PRIME 316LN</b>	0.027	1.38	0.52	0.012	0.009	12.50	18.89	2.45	0.01

### Mechanical Properties of Weld Metal

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)
<b>PRIME 308LN</b>	570	38
<b>PRIME 309LN</b>	560	39
<b>PRIME 316LN</b>	535	38

### Sizes Available and Recommended Currents (DC-)

Diameter (mm)	0.8	0.9	1.0
<b>Current (A)</b>	120-140	130-140	140-150
<b>Voltage (V)</b>	22-25	23-25	24-26

### Notes on Usage

- Use a DC power source with constant voltage and polarity DCEN
- The oil stains and rust on the weldments should be cleared away
- Designed for GAS FREE, SELF-SHIELDED (Gasless)
- Proper storage is recommended when open the packing