Technical data sheet 011121MBA	Cored welding wire # TETRA S 20 9 3-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	(E308MoT0-4 - E308MoT0-1)* nearest
EN ISO 17633-A:	T 20 10 3 R M21 3 - T 20 10 3 R C1 3
EN ISO 17633-B:	TS308Mo-F M21 0* – TS308Mo-F C1 0*

*Mo may exceed 3.0 %, Si may exceed 0.65 % and Cr may exceed 21.0 %

ASME IX Qualification	(QW432 F-N° 6 QW442 A-N° 8)*

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 20% chromium - 9% nickel - 3% molybdenum deposit
- Exceptional resistance to moisture pick-up
- Attractive bead appearance, automatic slag release, very good penetration and high productivity
- Excellent X-ray soundness
- Maximum performance in the flat and horizontal positions
- Welded with classical economic Ar-CO_2 mixtures or CO_2

APPLICATIONS

TETRA S 20 9 3-G offers a strong, tough crack free deposit suitable for fabricating tanks and other military vehicles.
It is also useful for welding high tensile steels and for joining 13% manganese steels, hardenable steels or wear-resistant steels.
It is used as a multi-purpose wire for maintenance and for welding dissimilar joints.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S	P
0.05	1.50	0.80	20.5	9.70	2.90	0.008	0.020

Typical ferrite level: 25 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
620	400	20	-20°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
710	530	30	-20°C: 45

SHIELDING GAS

M21 (Ar + 15 - 25% CO_2), M20 (Ar + 5%< CO_2 ≤ 15%) gas mixtures or C1 (CO_2) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Tension [V]	Stick-out [mm]	Gas flow
1.2	DC+	100 - 280	23 - 33	10 - 25	12 - 20 l/min.
1.6	DC+	150 - 400	23 - 35	10 - 25	12 - 20 l/min.

WELDING POSITIONS

Flat, horizontal

PACKAGING

Diameter	1.2 mm		1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us