Technical data sheet EN061124GB	Cored welding wire # TETRA V 16 8 2-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22-2024: EC16-8-2 (*nearest)
EN ISO 17633-A: T Z 16 8 2 P M21 1 - T Z 16 8 2 P C1 1
EN ISO 17633-B: TS 16-8-2-F M21 1 – TS 16-8-2-F C1 1
*This composition is not yet classified in AWS / ASME specifications for flux cored stainless steel electrodes. EC16-8-2 is the classification for metal cored electrodes.

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

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 16% chromium - 8% nickel - 2% molybdenum- bismuth free - controlled carbon deposit
- Specifically designed for out-of-position welding
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO_2 mixtures or CO_2

APPLICATIONS

TETRA V 16 8 2-G is used primarily for welding stainless steels that operate at temperatures up to about 800°C.
The deposit has excellent hot ductility and offers good resistance to weld cracking even under highly restrained conditions.
The very carefully balanced weld metal composition with a Ferrite Number no higher than 5 FN provides creep, oxidation and general corrosion resistance.

Examples:

AISI	UNS	Material number	EN Symbol
304H	S30409	1.4948	X6 CrNi 18-11
321H	S32109	1.4941	X8 CrNiTi 18-10
347H	S34709	1.4961	X8 CrNiNb 16-13
316H	S31609	1.4919	X6 CrNiMo 17-13

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S	P
0.06	1.4	0.5	16.5	9.60	1.20	0.008	0.020

Typical ferrite level: 4 FN
Bismuth < 0.002 %

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN[J]
520	320	25	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
620	460	40	+20°C: 70

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]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC (+)	130 - 270	22 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.2 mm	
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	S 200	BS 300
Weight	5 kg	15 kg

Other packaging and other diameters: please consult us