

**Technical  
data sheet**

011121MBA

**Cored welding wire****TETRA V 20 9 3-G****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22: (E308MoT1-4 - E308MoT1-1) nearest  
EN ISO 17633-A: T 20 10 3 P M21 1 - T 20 10 3 P C1 1  
EN ISO 17633-B : TS308Mo-F M21 1\* - TS308Mo-F C1 1\*  
\*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 - 10% nickel - 3% molybdenum deposit
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Specifically designed for out-of-position welding
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO<sub>2</sub> mixtures or CO<sub>2</sub>

**APPLICATIONS**

TETRA V 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	1.20	0.60	20.0	9.50	3.20	0.008	0.020

Typical ferrite level: 25 FN

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
620	400	30	-40°C: 32

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
730	570	32	-40°C: 45

**SHIELDING GAS**M21 (Ar + 15 - 25% CO<sub>2</sub>), M20 (Ar + 5% < CO<sub>2</sub> ≤ 15%) gas mixtures or C1 (CO<sub>2</sub>) 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	S200	BS300
Weight	5 kg	15 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.