

Technical data sheet

011121MBA

Cored welding wire
TETRA V 308H-G**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E308HT1-4 - E308HT1-1
EN ISO 17633-A:	T Z 19 9 H P M21 1 - T Z 19 9 H P C1 1
EN ISO 17633-B :	TS308H-F M21 1 – TS308H-F C1 1
Equivalent Material number :	1.4948
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 19% chromium - 9% nickel - high carbon 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-CO₂ mixtures or CO₂

APPLICATIONS

TETRA V 308H-G is suitable for welding 304H and 304H derivatives that operate at temperatures up to 750°C.

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

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Bi	S	P
0.06	1.40	0.80	20.5	10.5	< 0.002	0.008	0.020

Typical ferrite level: 5 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
550	320	35	+20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
625	470	40	+20°C: 60

SHIELDING GAS

M21 (Ar + 15 - 25% CO₂), M20 (Ar + 5% < CO₂ ≤ 15%) gas mixtures or C1 (CO₂) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC (+)	100 - 250	23 - 32	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.2 - 1.6 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.