Technical data sheet 011121MBA	Cored welding wire # TETRA V 308XL-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E308LT1-4
EN ISO 17633-A:	T 19 9 L P M21 1
EN ISO 17633-B:	TS308L-F M21 1
Equivalent Material number:	1.4316
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 - low carbon deposit, with controlled ferrite number for optimum toughness
- 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 economical Ar-CO_2 mixtures
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APPLICATIONS

TETRA V 308XL-G is suitable for welding 308L stainless steels type and is specifically dedicated for cryogenic application and LNG (thanks to the controlled ferrite)
Used to weld 18-8 stainless steels with process temperatures down to -196°C

Examples:

AISI	UNS	Material number	EN Symbol
304	S30400	1.4301	X5 CrNi 18-10
304L	S30403	1.4306	X2 CrNi 19-11
304LN	S30453	1.4311	X2 CrNiN 18-10
308	S30800	1.4303	X4 CrNi 18-12

TYPICAL ALL-WELD METAL ANALYSIS [Wt.%]

C	Mn	Si	Cr	Ni	S	P
0.03	1.4	0.5	19	11	0.008	0.02

Typical ferrite level: 4 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
520	320	35	-196°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
620	460	40	-196°C: 40

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15 - 25% CO_2)

OPERATING CONDITIONS

Diameter [mm]	Current type	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow rate
0.9	DC+	100 - 250	20 - 32	12 - 20	10 - 20 l/min.
1.2	DC+	130 - 270	22 - 35	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	BS300
Weight	15 kg

Other packaging and other diameters: please consult us