Technical data sheet 011121MBA	Cored welding wire # TETRA V 309LNb-G	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22 :	E309LNbT1-4 - E309LNbT1-1
EN ISO 17633-A :	T Z 23 12 Nb P M21 1 - T Z 23 12 Nb P C1 1
EN ISO 17633-B :	TS309LNb-F M21 1 - TS309LNb-F C1 1
Equivalent Material number :	-
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 23% chromium - 12% nickel - niobium stabilised - low carbon deposit
- Specifically designed for out-of-position welding and cladding
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO_2 mixtures or CO_2

APPLICATIONS

- Buffering mild and low alloyed steels in AISI 347 and AISI 321 claddings
- First run when welding 347 or 321 clad steels prior to completion with TETRA S/V 347L-G

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Nb	S	P
0.025	1.40	0.70	23.0	12.5	0.80	0.008	0.020

Typical ferrite level: 15 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
520	320	25	+ 20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
650	480	35	+ 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	Intensity [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 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