

**Technical  
data sheet**

011121MBA

**Cored welding wire**  
**TETRA V LD62-G****CLASSIFICATION**

EN ISO 17633-A:

T 23 7 N L P M21 1 - T 23 7 N L P C1 1

**DESCRIPTION**

- Rutile flux cored stainless steel wire for gas shielded arc welding
- Lean duplex stainless steel 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<sub>2</sub> mixtures or CO<sub>2</sub>

**APPLICATIONS**

Welding wrought, forged or cast lean duplex stainless steels.

Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.

**Examples:**

UNS	Material number	EN Symbol
S32001		
S32304	1.4362	X2CrNiN 23 4
S32101	1.4162	X2CrMnNiN 22-5-2
S32003		
S32202	1.4062	

**TYPICAL ALL-WELD METAL ANALYSIS**

C	Mn	Si	Cr	Ni	Mo	N	S	P
0.02	1.8	0.7	24.0	8.5	0.2	0.18	0.008	0.020

Typical ferrite level: 35 FN

PRE<sub>N</sub> = Cr + 3.3 Mo + 16 N ≥ 25**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
650	450	25	- 40°C: 32

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
740	580	30	- 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	
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M	
	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.