

Technical data sheet

EN130326GB

Cored welding wire**TUBE S 20 9 3-G****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22: (EC308Mo)*
 EN ISO 17633-A: T 20 10 3 M M12 1
 EN ISO 17633-B: TS308Mo-MG0*
 *Mo may exceed 3.0 % and Cr may exceed 21.0 %
 ASME IX Qualification QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Metal cored stainless steel wire for gas shielded arc welding
- 20% chromium - 9% nickel - 3% molybdenum deposit
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness

APPLICATIONS

- Welding stainless steels of similar composition or ferritic stainless steels
- Joining stainless steels to mild and low-alloyed steels
- Buffer layers before hardfacing
- Maintenance on « hard-to-weld steels »
- Welding of high hardness armour plates, high carbon hardenable steels, of known or unknown composition and generally most of steels subject to cracking such as tool steels, manganese steels, spring steels and high-speed steels

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S	P
0.05	1.5	0.8	20.5	9.7	3.2	0.008	0.020

Typical ferrite level: 20 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
620	400	30	+ 20°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
780	600	35	+ 20°C: 60

SHIELDING GAS

EN ISO 14175: M12 Ar + 0.5 % < CO₂ ≤ 2.5 %, with or without Helium
 Z Ar + CO₂ ≤ 0.5 % or O₂ ≤ 0.5 %, with or without Helium
 I1 Ar
 M13 Ar + 0.5 % < O₂ ≤ 3.0 with or without Helium

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick out [mm]	Gas flow rate [l/min]
1.2	DC (+)	95 - 270	16 - 31	12 - 25	10 - 20

Recovery of 98 %

WELDING POSITIONS

EN ISO 6947: PA, PB
 ASME IX: 1G, 1F, 2F

Tube S 20 9 3-G is primarily used in the flat and horizontal-vertical positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm		1.6 mm	
	EN ISO 544 – ASME II C SFA-5.2 M			
Spool type	S200	BS300	BS300	
Weight	5 kg	15 kg	15 kg	

Other packaging: please consult us

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