Technical data sheet EN030225GB	Cored welding wire # WA TUB SS 9L	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E309LT1-1 - E309LT1-4
EN ISO 17633-A:	T 23 12 L P C1 1 / T 23 12 L P M21 1
Equivalent Material number:	1.4332
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 24% chromium - 13% nickel - low carbon 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
- Excellent weldability with CO_2 or Ar/CO_2 shielding gas

APPLICATIONS

- Welding stainless steels of similar composition or ferritic stainless steels.
- Joining stainless steels to mild and low-alloyed steels.
- Rebuilding and buffering before cladding or hardfacing.
- Maintenance on “hard-to-weld” steels.

Examples

Dissimilar welds between stainless steel types 304, 304L, 316, 316L, 318, 316Ti, 321, 410 or ferritic stainless steel types 1.4713, 1.4724, 1.4742, 3Cr12, to non or low alloyed CMn steels, for service temperatures up to 400°C.

ISO/TR 15608: Groups 1, 2, 3 and 4 to groups 7, 8 and 10.
Group 7 to groups 8 and 10.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.03	1.40	0.70	23.5	13.0	0.008	0.020

Typical ferrite level: 20 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
520	320	30	---

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
580	460	35	+20°C : 50

SHIELDING GAS

C1 (CO_2) or M21 (Ar + 15-25% CO_2) gas mixtures according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Intensity [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.0	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	1.0 mm	1.2 mm
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	BS 300	
Weight	15 kg	

Other packaging and other diameters: please consult us