Technical data sheet EN030225GB	Cored welding wire # WA TUB SS 12	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E312T1-1 - E316LT1-4
EN ISO 17633-A:	T 29 9 P C1 1 - T 29 9 P M21 1
Equivalent Material number :	1.4337
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 29% chromium - 9% nickel deposit
- 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 economic Ar-CO_2 mixtures or CO_2
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APPLICATIONS

WA TUB SS 12 has high alloy content and high ferrite which give extreme tolerance to hot cracking and to dilution with a wide range of base materials. Preheat can often be avoided or minimised.
The weld deposit work hardens and gives good wear and friction resistance.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S	P
0.10	1.30	0.80	29.0	8.60	0.30	0.008	0.020

Typical ferrite level: 50 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
660	450	15	+20°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
800	610	20	+20°C: 40

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	Cutrrent [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