

Technical data sheet <small>011121MBA</small>	Cored welding wire WA TUB SS R9L	
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CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E309LT0-1 - E309LT0-4
EN ISO 17633-A:	T 23 12 L R C1 3 - T 23 12 L R M21 3
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 metal arc welding
- 24% chromium - 13% nickel - low carbon deposit
- Attractive bead appearance, automatic slag release, very good penetration and high productivity
- Excellent X-ray soundness
- Maximum performance in the horizontal and downhand positions
- Welded with CO₂ or classical economic Ar-CO₂ mixtures

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]	As [%]	CVN [J]
520	320	25	0°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
580	460	35	0°C: 50

SHIELDING GAS

C1 (CO₂) or M21 (Ar + 15 - 25% CO₂) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC (+)	140 - 250	23 - 33	15 - 25	15 - 25 l/min.
1.6	DC (+)	150 - 320	23 - 35	15 - 25	15 - 25 l/min.

WELDING POSITIONS

Flat, Horizontal

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	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.