


Technical data sheet <small>011121MBA</small>	Cored welding wire TETRA S LD62-G	
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CLASSIFICATION

EN ISO 17633-A: T 23 7 N L R M21 3 - T 23 7 N L R C1 3

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- Lean duplex stainless steel deposit
- Exceptional resistance to moisture pick-up
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Maximum performance in the flat and horizontal positions
- Welded with classical economic Ar-CO₂ mixtures or CO₂

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	Cu	N
0.03	1.4	0.6	24	8.5	0.2	0.3	0.2

Typical ferrite level: 35 FN
PRE_N = Cr + 3.3 Mo + 16 N ≥ 25

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
570	450	20	- 40°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
750	600	28	- 50°C: 35

SHIELDING GAS

M21 (Ar + 15 - 25% CO₂), M20 (Ar + 5% < CO₂ ≤ 15%) gas mixtures, or C1 (CO₂) according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	100 - 270	23 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

Flat, Horizontal

PACKAGING

Diameter	1.2 mm	
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	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.