

Technical data sheet

011121MBA

Cored welding wire

TETRA V 309LNb-G**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22 :	E309LNbT1-4 - E309LNbT1-1
EN ISO 17633-A :	T Z 23 12 Nb P M21 1 - T Z 23 12 Nb P C1 1
EN ISO 17633-B :	TS309LNb-F M21 1 - TS309LNb-F C1 1
Equivalent Material number :	-
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 23% chromium - 12% nickel - niobium stabilised - low carbon deposit
- Specifically designed for out-of-position welding and cladding
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO₂ mixtures or CO₂

APPLICATIONS

- Buffering mild and low alloyed steels in AISI 347 and AISI 321 claddings
- First run when welding 347 or 321 clad steels prior to completion with TETRA S/V 347L-G

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Nb	S	P
0.025	1.40	0.70	23.0	12.5	0.80	0.008	0.020

Typical ferrite level: 15 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
520	320	25	+ 20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
650	480	35	+ 20°C: 45

SHIELDING GASM21 (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	Intensity [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	100 - 250	23 - 32	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

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.