


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>TETRA V 316H-G</b>	
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### CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22	E316HT1-4 - E316HT1-1
EN ISO 17633-A	T Z 19 12 3 H P M21 1 - T Z 19 12 3 H P C1 1
EN ISO 17633-B	TS 316H-F M21 1
Equivalent Material number	1.4430
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

### DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 19% chromium - 12% nickel - 3% molybdenum - controlled carbon deposit for high temperature properties
- Attractive bead appearance, very good penetration, high productivity and excellent X-ray soundness
- Specifically designed for out-of-position welding
- Maximum productivity for completion of vertical welds
- Welded with classical economical Ar-CO<sub>2</sub> mixtures or CO<sub>2</sub>

### APPLICATIONS

TETRA V 316H-G is suitable for welding stainless steels of similar composition operating at temperatures up to 750°C under long term creep conditions. It is mainly used for high-temperature plant and components in thermal and in the chemical and petrochemical industries.

#### Examples:

AISI	UNS	Castings	Material number	EN Symbol
316H	S31609	CF10M	1.4919	X6 CrNiMo 17 13

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Bi	S	P
0.06	1.40	0.80	18.5	11.5	2.60	< 0.002	0.008	0.020

Typical ferrite level: 6 FN

### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
520	320	30	+20°C: 32

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
600	470	35	+20°C: 55

### SHIELDING GAS

M21 (Ar + 15 - 25% CO<sub>2</sub>), M20 (Ar + 5% < CO<sub>2</sub> ≤ 15%) gas mixtures or C1 (CO<sub>2</sub>) according to EN ISO 14175

### OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.2	DC+	130 - 270	22 - 35	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	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.