

Technical data sheet

011121MBA

Cored welding wire

TETRA V 329-G**CLASSIFICATION**

EN ISO 17633-A: T Z 25 4 P M21 1 – T Z 25 4 P C1 1
 Equivalent Material number: 1.4820

DESCRIPTION

- Rutile flux-cored stainless steel wire with fast freezing slag for gas shielded arc welding
- 25% chromium - 4% nickel - high carbon deposit
- Specifically designed for out-of-position welding, maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO₂ mixtures or CO₂

APPLICATIONS

TETRA V 329-G is suitable for high temperature applications where the nickel content of the filler material must be kept as low as possible. It is used for joining refractory Cr-Al-Si steels - as a general rule for stainless steels containing 8 to 24% chromium with silicon and/or aluminium additions - or for cladding corrosion resistant overlays.

Examples:

WNr	EN	ASTM/ACI	WNr	EN	ASTM/ACI
1.4710	G-X30CrSi6		1.4745	G-X40CrSi23	TP433
1.4712	X10CrSi6	502	1.4762	X10CrAl24	TP443
1.4713	X10CrAl7	502	1.4773	X8Cr30	
1.4722	X10CrSi13		1.4776	G-X40CrSi29	
1.4724	X10CrAl13	TP405-CA15	1.4820	G-X12 CrSi 26 5	
1.4729	G-X40CrSi13		1.4821	X20 CrNiSi 25 4	TP329
1.4740	G-X40CrSi17		1.4822	G-X40CrNi 25 4	TP329
1.4742	X10CrAl18	430B-TP430	1.4823	G-X40CrNiSi 27 4	TP329HC

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.08	0.70	0.80	25.0	4.00	0.008	0.020

Typical ferrite level: 80 FN (The structure is essentially ferritic with intragranular austenite)

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
600	400	15	+20°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
750	570	20	+20°C: 45

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.
1.6	DC (+)	150 - 400	23 - 37	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.