

Technical data sheet

011121MBA

Cored welding wire
TETRA V 904L-G**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22: (E385T1-4)*
 EN ISO 17633-A: T Z 20 25 5 Cu L P M21 3
 EN ISO 17633-B: TSZ385-F M21 1
 Equivalent Material number: 1.4519

* This grade is not yet classified in AWS and ASME specifications for stainless steel electrodes for flux cored arc welding

*(ASME IX Qualification QW432 F-N° -- QW442 A-N° 9)

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 20% chromium - 25% nickel – 4.5% molybdenum – 1.5% copper - low carbon deposit
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Good resistance to hot cracking
- Specifically designed for out-of-position welding
- Maximum productivity for completion of vertical welds
- Welded with classical economic Ar-CO₂ mixtures

APPLICATIONS

TETRA V 904L-G is suitable for welding stainless steels of similar composition and for dissimilar welds between these steels and mild, low alloy and other stainless steels. It is an alternative choice to overmatch leaner alloys such as 317LN, 1.4439 etc.

Examples:

AISI	UNS	Material number	EN Symbol
		1.4500	GX7 NiCrMoCuNb 25-20
		1.4505	X4 NiCrMoCuNb 20-18-2
		1.4506	X5 NiCrMoCuTi 20-18
		1.4536	GX2 NiCrMoCuN 25-20
	N08904	1.4539	X1 NiCrMoCu 25-20-5
		1.4585	GX7 CrNiMoCuNb 18-18

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.03	3.2	0.5	20	26	5	1.6	0.008	0.020

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
510	320	25	- 196°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
640	430	32	- 196°C: 35

SHIELDING GAS

M21 (Ar + 15 - 25% CO₂) gas mixtures according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow rate
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 spool	BS300 basket spool
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.