

**Technical
data sheet**

011121MBA

**Cored welding Wire
TRI S RW-O****CLASSIFICATION**

EN ISO 17633-A: T Z 19 9 Mn U NO 3
EN 14700: T Fe10

DESCRIPTION

- Flux cored self-shielded stainless steel wire for open arc welding
- Austenitic deposit with exceptional resistance to both hot and cold cracks
- Specially designed slag, easy to remove
- Excellent bead appearance
- Very good radiographic quality
- High productivity compared to SMAW stick electrodes and GMAW solid wires
- May be used outdoors, even under difficult atmospheric conditions

APPLICATIONS

TRI S RW-O is specially designed for joining rails.

Examples

Ductile assembly of C-Mn rails (R200; R260, R290GHT, etc.)

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.1	6.5	1	19	9	0.01	0.02

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm (MPa)	Rp0.2% (MPa)	As [%]	CVN [J]
710	530	40	+20°C: 60

Hardness – 3-layer deposit:

As welded: 180 HB

Work hardened: 47 HRc

SHIELDING GAS

None

OPERATING CONDITIONS

Diameter (mm)	Current (A)	Voltage (V)	Stick-out (mm)
2.0	250 – 320	28 – 31	25 – 35

When assembling rails, the joint must be preheated to avoid the formation of brittle heat-affected zones. Slow cooling is also required.

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	2.0 mm
Spool type	EN ISO 544: BS300
Weight	15 kg

Other packaging and other diameters: please consult us