

**Technical
data sheet**

011121MBA

**Cored welding wire
TUBE S 309L-S****CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	EC309L
ASME IIC SFA 5.9 / AWS A 5.9:	EC309L
EN ISO 17633-A:	T 23 12 L M NO 3
Equivalent Material number:	1.4332
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Cored stainless steel wire for submerged arc welding
- 24% chromium - 13% nickel - low carbon deposit
- Attractive bead appearance without residual slag, outstanding slag release even in narrow gaps
- Excellent weld metal quality and X-ray soundness
- High productivity
- Enhanced wetting properties compared to matching solid wires

APPLICATIONS

- Welding stainless steels of similar composition or ferritic stainless steels.
- Joining stainless steels to mild and low-alloyed steels.
- Rebuilding and buffering before cladding or hardfacing.
- Maintenance on « hard-to-weld steels ».

Examples

Dissimilar welds between stainless steels type 304, 304L, 316, 316L, 318, 316Ti, 321, 410 or ferritic stainless steels type 1.4713, 1.4724, 1.4742, 3Cr12, to non or low alloyed CMn steels, for service temperatures up to 400°C.

ISO/TR 15608: Groups 1, 2, 3 and 4 to groups 7, 8 and 10.
Group 7 to groups 8 and 10.

TYPICAL ALL-WELD METAL ANALYSIS WITH FLUX WAF 385

C	Mn	Si	Cr	Ni	S	P
0.02	1.40	0.60	24.0	13.0	0.008	0.015

Typical ferrite level: 20 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES WITH FLUX WAF 385

Rm [MPa]	Rp0.2% [MPa]	A5 [%]	CVN [J]
520	320	25	+ 20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES WITH FLUX WAF 385

Rm [MPa]	Rp0.2% [MPa]	A5 [%]	CVN [J]
580	470	35	+ 20°C: 65

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	2.0 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M
	Coil: B450
Weight	25 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.