


Technical data sheet <small>011121MBA</small>	Cored welding wire TUBE S 361-G	
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CLASSIFICATION

EN ISO 17633-A: T Z 19 13 Si N L M M12 1
 Equivalent Material number 1.4361

DESCRIPTION

- Metal cored stainless steel wire for gas shielded arc welding
- Weld metal designed to join stainless steel 1.4361
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness

APPLICATIONS

TUBE S 361-G is suitable for welding silicon enhanced austenitic stainless steels

Examples (non-exhaustive list):

UNS	Material number	EN Symbol
S30600	1.4361	X1 CrNiSi 18-15-4
S32615		

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	N	S	P
0.02	1.7	4.0	19.5	13	0.10	0.006	0.020

Typical ferrite level: 15 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
660	390	20	+20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
780	520	30	+ 20°C: 55

SHIELDING GAS

EN ISO 14175 : M12 Ar + 0.5 % < CO₂ ≤ 2.5 with or without helium
 Z Ar + CO₂ ≤ 0.5 % or O₂ ≤ 0.5 % with or without helium
 I1 Ar

OPERATING CONDITIONS

Current type	Gas flow rate	Stick out	Recovery
DC+ / pulsed	10 - 20 l/min.	12 - 25 mm	98 %

WELDING POSITIONS

TUBE S 361-G is primarily used in the flat and horizontal positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

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