


Technical data sheet <small>150222JMBA</small>	Cored welding wire TUBE S LD62-G	
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CLASSIFICATION

EN ISO 17633-A: T Z 24 8 N L M M12 1

DESCRIPTION

- Metal cored stainless steel wire for gas shielded metal arc welding
- High strength lean duplex stainless steel deposit
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness
- Welded with classical economical Ar-CO₂ gas mixtures

APPLICATIONS

- Welding wrought, forged or cast lean duplex stainless steels.
- Heterogeneous welding between duplex stainless steels and other stainless and mild or low alloyed steels.

Examples:

UNS	Material number	EN Symbol
S32001		
S32304	1.4362	X2CrNiN 23 4
S32101	1.4162	X2CrMnNiN 22-5-2
S32003		
S32202	1.4062	

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	N	S	P
0.02	2.0	0.6	24.0	8.5	0.1	0.18	0.008	0.020

Typical ferrite level: 35 FN
 PRE_N = %Cr + 3.3 %Mo + 16 %N ≥ 25

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A5 %	CVN [J]
650	450	25	+20°C: 40

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A5 %	CVN [J]
750	570	30	-40°C: 32

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
 M13 Ar + 0.5 % < O₂ ≤ 3.0 with or without helium

OPERATING CONDITIONS

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

WELDING POSITIONS

TUBE S LD62-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		1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 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.