

Technical data sheet

011121MBA

Coated SMAW Electrode**WA TETRA V 308Mo-E****CLASSIFICATION**

ASME IIC SFA 5.4 / AWS A 5.4: (E308Mo-16) nearest
 EN ISO 3581-A: E 22 10 3 R 32

DESCRIPTION

- Rutile coated stainless-steel electrode
- 20% chromium - 10% nickel - 3% molybdenum composition
- Strong, tough and crack-resistant austenitic-ferritic deposit
- Stable fusion, good slag removal, weld deposit with good appearance
- Complements Welding Alloys cored wires TETRA V DISSIM-G and TETRA S 20 9 3-G

APPLICATIONS

WA TETRA V 308Mo-E offers a strong, tough crack free deposit suitable for fabricating tanks and other military vehicles.

It is also useful for welding high tensile steels and for joining 13% manganese steels, hardenable steels or wear-resistant steels.

It is used as a multi-purpose wire for maintenance and for welding dissimilar joints.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo
0.04	0.7	0.8	20.5	10.5	3.0

Typical ferrite level: 25 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
620	450	30	-40°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
730	570	35	-40°C: 45

WELDING CONDITIONS

Electrode ØxL [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	50 - 80	80 - 115	90 - 140
= +	~ 70V		

Re-drying: 1h at 250°C, if necessary.

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PD, PE, PF
 ASME IX: 1F, 1G, 2F, 2G, 3F, 3G, 4F, 4G

PACKAGING

Electrode ØxL [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	5.0		

Other packaging and other sizes: 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.