

Technical data sheet

011121MBA

Cored welding wire
WA TUB SS 8L**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	E308LT1-1 - E308LT1-4
EN ISO 17633-A:	T 19 9 L P C1 1 - T 19 9 L P M21 1
Equivalent Material number :	1.4316
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 8

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 19% chromium - 9% nickel - low carbon deposit
- Specifically designed for out-of-position welding
- Attractive bead appearance, very good penetration, excellent X-ray soundness
- Maximum productivity for completion of vertical welds
- Excellent weldability with CO₂ or Ar/CO₂ shielding gas

APPLICATIONS

WA TUB SS 8L is suitable for welding stainless steels with an alloy content between 16 to 21% Cr and 8 to 13% Ni, stabilised or not.

Examples:

AISI	UNS	Material number	EN Symbol
302	S30200	1.4300	X12 CrNi 18 8
304	S30400	1.4301	X5 CrNi 18-10
304L	S30403	1.4306	X2 CrNi 19-11
304LN	S30453	1.4311	X2 CrNiN 18-10
305	J92701	1.4312	GX10 CrNi 18-8
308	S30800	1.4303	X4 CrNi 18-12
321	S32100	1.4541	X6 CrNiTi 18-10
347	S34700	1.4550	X6 CrNiNb 18-10

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	S	P
0.03	1.40	0.70	20.0	10.5	0.008	0.020

Typical ferrite level: 8 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
520	320	35	---

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
620	460	40	+20°C: 80

SHIELDING GAS

C1 (CO₂), M21 (Ar + 15 - 25% CO₂) gas mixtures according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow
1.0	DC+	100 - 250	20 - 32	12 - 20	10 - 20 l/min.
1.2	DC+	130 - 270	22 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

PACKAGING

Diameter	1.0 mm	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

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.