

Technical data sheet <small>011121MBA</small>	Cored welding wire WA TUB SS 8LNb	
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CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	E347T1-1 - E347T1-4
EN ISO 17633-A:	T 19 9 Nb P C1 1 - T 19 9 Nb P M21 1
Equivalent Material number:	1.4551
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 - niobium stabilised - low carbon deposit
- Attractive bead appearance, very good penetration and high productivity
- Excellent X-ray soundness
- Specifically designed for out-of-position welding
- Maximum productivity for completion of vertical welds
- Excellent weldability with CO₂ or Ar/CO₂ shielding gas

APPLICATIONS

WA TUB SS 8LNb is suitable for welding stabilised stainless steels containing 16 to 21% Cr and 8 to 13% Ni

Examples:

AISI	UNS	Material number	EN Symbol
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	Nb	S	P
0.03	1.40	0.70	19.0	10.5	0.50	0.008	0.020

Typical ferrite level: 8 FN

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A ₅ [%]	CVN [J]
550	350	25	---

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A ₅ [%]	CVN [J]
660	470	35	+20°C: 90

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
1.2	DC+	130 - 270	22 - 35	12 - 25	10 - 20 l/min.

WELDING POSITIONS

All positions

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