


<b>Technical data sheet</b>  <small>120422JMBA</small>	<b>Cored welding wire</b>  <b>TRI V 19 9 6-O</b>	
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### CLASSIFICATION

EN ISO 17633-A: T Z 18 8 Mn N P NO 1 - T Z 18 8 Mn N P C1 1\*  
ASME IIC SFA 5.22 / AWS A 5.22: (E307T1-4 - E307T1-1) nearest\*  
Nearest equivalent Material number: 1.4370

\* TRI V 19 9 6-O contains no added Mo, is strengthened and stabilised by nitrogen and is typically alloyed with 6% Mn

### DESCRIPTION

- Self-shielded stainless steel cored wire with a fully alloyed austenitic strip
- Produces a chromium - nickel - high manganese tough and ductile stainless steel deposit
- Optimised for repair and maintenance application
- Attractive bead appearance, very good penetration
- Excellent X-ray soundness
- Specifically designed for out-of-position welding
- Ideal for completion of vertical welds, high productivity compared to manual electrodes
- Sound deposits are obtained even in the presence of cross draughts
- Provides maximum productivity for outdoor jobs
- Can be welded with an external gas shield such as CO<sub>2</sub>

### APPLICATIONS

- Repair jobs on high carbon equivalent steels and thick or restrained parts
- Joining austenitic manganese steels to themselves or to other steels.
- Buffer layer on manganese steels, or on hardenable and unknown steels, before hardfacing.
- Maintenance on air hardenable and "hard-to-weld" steels.
- Armour plate.

### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	N
0.1	6.5	0.8	19	8.2	0.1

Typical ferrite level: 8 FN

### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
500	350	25	+20°C: 40

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
650	490	35	+20°C: 80

Hardness – as welded: 170 HB

Hardness – after cold working: 500 HB

### SHIELDING GAS

None or C1 (100% CO<sub>2</sub>) according to EN ISO 14175

### OPERATING CONDITIONS - Self shielded - Diameter 1.2 mm

Position EN ISO 6947 / ASME IX	Current type	Technique	Current intensity [A]	Voltage [V]	Stick out [mm]
PA-PB / 1G, 1F, 2F	DC+	Stringer bead	160 - 180	27 - 29	≥ 15
PF / 3Gu	DC+	Oscillated bead	130 - 150	24 - 25	25 - 30

### WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF

ASME IX: 1F, 1G, 2F, 2G, 3F, 3G, 4F, 4G, 5G

### PACKAGING

Diameter	1.2 mm	
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	S200	BS300
Weight	5 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.