

Technical data sheet <small>011121MBA</small>	Cored welding wire TETRA V DISSIM-G	
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CLASSIFICATION

EN ISO 17633-A: T Z 20 10 3 P M21 1 - T Z 20 10 3 P C1 1

DESCRIPTION

- Rutile flux cored stainless steel wire for gas shielded arc welding
- 21% chromium - 9% nickel - 3% molybdenum - nitrogen stainless steel deposit
- Specifically designed for out-of-position welding
- Good slag detachment, attractive bead appearance and very good penetration
- Excellent X-ray soundness
- Maximum productivity for completion of vertical welds
- Welded with classical economical Ar-CO₂ mixtures or CO₂

APPLICATIONS

TETRA V DISSIM-G gives a highly crack-resistant deposit. It is a multi-purpose product suited to welding dissimilar alloys and for maintenance work. It may be used to weld high-strength steels, wear-resistant steels, heat treatable steels and manganese steels.

It is used for constructing tanks and other military vehicles.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	N
0.06	1	0.6	21.5	9.3	2.9	0.08

Typical ferrite level: 23%

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
620	400	22	-40°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
770	600	28	-40°C: 45

SHIELDING GAS

M21 (Ar + 15 - 25% CO₂), M20 (Ar + 5 - 15% CO₂) gas mixtures or C1 (CO₂) 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	
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M	
	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.