


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Cored welding wire</b>  <b>TRI S 19 17 5L-O</b>	 <b>Welding Alloys</b>
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#### CLASSIFICATION

EN ISO 17633-A: T Z 19 17 5 Mn L U NO 3  
EN 14700: T ZFe12

#### DESCRIPTION

- Special flux cored self-shielded stainless steel wire for open arc welding
- The produced weld beads have a self-releasing slag covering which leaves a clean surface
- Sound deposits are obtained even in the presence of cross draughts
- Primary choice for cladding

#### APPLICATIONS

The TRI S series of wires is designed for on-site weld surfacing, repair and assembly of stainless steels. Good quality welds may be obtained, even when they are used in difficult weather conditions.

TRI S 19 17 5L-O is a self-shielding cored wire which deposits a modified 317L stainless steel composition for cladding steels used in the fabrication of hot-dip zinc galvanising baths and kettles. High nickel levels and carefully controlled composition promote a fully austenitic microstructure combined with increased manganese content to ensure freedom from microfissuring. This alloy has the necessary properties to control the rate of rapid corrosion of low silicon steels by Zn and Zn-Al alloys used for hot dip galvanising.

#### Examples

Direct cladding of CMn materials used in the fabrication of galvanising baths, kettles and ancillary equipment. Ideal for cladding galvanising bath rolls and other ancillary equipment used in continuous dip plants

#### TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	S	P
0.03	4.7	0.6	19.3	17.3	4.6	0.008	0.020

#### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
480	300	25	+20°C: 40

#### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
600	450	30	+20°C: 50

#### SHIELDING GAS

None

#### OPERATING CONDITIONS

Current type	Gas flow rate	Stick out	Recovery
DC+	-	25 - 45 mm	88 %

#### WELDING POSITIONS

Flat, half up, half down

#### PACKAGING

Diameter	1.6 mm	2.0 mm	2.4 mm
Spool type	EN ISO 544: 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.