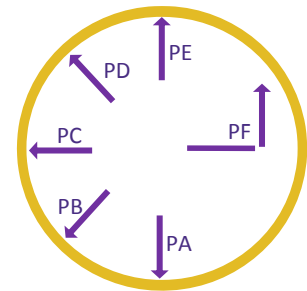


Applications

- 23.5%Cr-13%Ni Stainless steel.
- Dissimilar welds between carbon, low alloy steels to stainless steels.
- Buffer layer welding for cladding, overlays.

Features

- Good performance in all positions.



Typical Chemical Properties of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo
100% CO ₂	0.027	0.74	1.27	0.021	0.006	12.99	23.36	0.130
80%Ar+20%CO ₂	0.026	0.86	1.43	0.021	0.006	12.82	23.52	0.130

Typical Mechanical Properties of All-Weld Metal

	TS (Mpa)	EL(%)	Temp °C	Impact (J)
100% CO ₂	540	41	-60	46
80%Ar+20% CO ₂	580	39	-60	40

Current

DC +

Shielding Gas

100% CO₂
80%Ar+20% CO₂