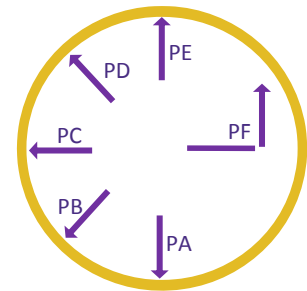


Applications

- 18%Cr-12%Ni -2%Mo 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	0.025	0.90	1.25	0.013	0.008	11.80	17.54	2.63
80%Ar+20%CO ₂	0.025	0.92	1.38	0.013	0.008	11.73	17.54	2.63

Typical Mechanical Properties of All-Weld Metal

	TS (Mpa)	EL(%)	Temp °C	Impact (J)
100% CO ₂	550	45.6	-60	45
80%Ar+20% CO ₂	555	42.4	-60	45

Current

DC +

Shielding Gas

100% CO₂
80%Ar+20% CO₂