

## A flux - cored gas shielded wire for corrosion resistant joining of wide grades of stainless steels to dissimilar steels

### Typical Application:

For joining Stainless Steels of type 18Cr/8Ni with other dissimilar Steels. Also suitable as a buffer layer for cladding.

### Outstanding Features:

Optimum ferrite content of weld deposit assures total freedom from cracking despite dilution. The weld bead is uniform, flat to concave & free from porosity.

### Code & Specifications:

ASME SFA 5.22 Class E309LT1-1

### Technical Characteristics:

Typical All Weld Chemistry (Wt%)

C	Si	Mn	Cr	Ni
0.03	0.30	1.50	24.00	13.00

### Recommended Amperages

Size (mm)	1.6	2.40
Welding Current	150-230	200-320
Arc Voltage	25-32	26-34

The product is also available as per the following AWS specification :  
ASME SFA 5.22 Class E309LT1-4

\* Terms & conditions apply .