

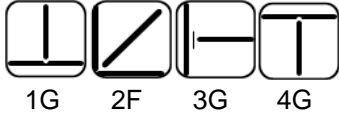
**Applications**

Used to weld type 321, 347 & 348 stainless steel for joining & cladding application on Niobium and Titanium stabilized stainless steel.

**Characteristics on Usage**

A lime titania all position stainless steel flux cored wire gives 19.% Cr, 10% Ni, & 0.35% Niobium weld deposit with Co2 gas shield. The weld metal is excellent resistance to intergranular corrosion, stable arc with improved weld pool control for weldability, bright finely rippled weld bead, reduces chromium carbide precipitation etc. Weld metal is of radiographic quality with easy slag removal and low spatters.

**Welding Positions**



**Recommended Stick Out**

15 - 20mm

**Shielding Gas**

Carbon Dioxide (CO2) shielding  
Gas Flow :15-20 Lit / Min

**Chemical Composition Of Weld Metal**

Element	C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo %	Cu %
Typical Values	0.030	1.50	0.65	0.010	0.030	19.50	10.2	0.015	0.105
Spec. Req. d.	0.080	0.5-2.50	1.0 Max	0.030	0.040 Max	18.0-21.0	9.0-11.0	0.75 Max	0.75 Max

**Nb%**

0.40

1.0 Max

**Mechanical Properties Of Weld Metal**

Property	U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %
Typical Values	590	35
Spec. Req. d.	520 Min	30 Min

**Welding Parameters (DC + VE)**

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.20	160-210	26-30	120-210	22-26	160-210	26-30
1.60	190-250	26-30	160-250	21-27	190-250	26-30

**Packing**

12.5 kgs. vaccum packed plastic spool.