

## Applications

Mig Welding of 13%Cr stainless steel (STS 403, STS 410)

## Characteristics on Usage

Structure of all-weld metal is martensite having magnetic properties thus providing high hardness, good anti-abrasive property.

Due to excellent resistance to corrosion and abrasion, It can be used to hardfacing application.

### Typical Chemical Composition of Wire (%)

C	Si	Mn	Cr	Ni
0.10	0.38	0.34	12.0	0.17

### Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in <sup>2</sup> )	EL (%)
540 (78,300)	35

### Typical Welding Conditions (DC+)

Size mm(in)	A	V	Speed (cm/min.)	Gas Flow (ℓ /min.)	Remarks
1.2 (.045)	250	26	30	25	Shielding gas
1.6 (1/16)	300	29	35	25	100%Ar or Ar+2%O <sub>2</sub>