



COR-MET, INC.
12500 GRAND RIVER ROAD
BRIGHTON, MI 48116-8326
(810) 227-3251
800-848-2719
FAX: (810) 227-9266
www.cor-met.com

COR™STAIN GAS SHIELDED FC-G

DESCRIPTION

COR™STAIN 300 series flux-cored stainless steel wires are formulated for gas shielded welding in the flat and horizontal position. The arc action is a smooth, globular transfer, and the slag is easily removed. The resulting weld deposits exhibit excellent strength, ductility and corrosion resistance. The wires can be formulated with controlled ferrite numbers, and alloy ranges as requested.

APPLICATIONS

COR™STAIN 300 series flux-cored stainless steel wires are used for joining base metals of matching or similar composition. They are also used to clad a lower alloy material. Typical uses include marine, chemical, and petroleum.

PROCEDURE

Standard practices for welding austenitic stainless apply. No preheat is required. Maintain a 300°F maximum interpass temperature.

AVAILABILITY

308, 309,310, 316, 317, 320, 347 in L, H, Mo, Cb, Ti. Others available upon request.

WELDING PARAMETERS

	Size	Volts	Amps	Stickout	Shielding Gas
FC-G	.045"	24-28	100-140	0.5"	100%CO ₂ or 75Ar-25CO ₂
FC-G	1/16"	24-28	150-250	0.75"	100%CO ₂ or 75Ar-25CO ₂
FC-G	3/32"	26-30	250-450	0.75"	100%CO ₂ or 75Ar-25CO ₂

MECHANICAL PROPERTIES

According to AWS, A5.22 where applicable

CLASSIFICATION

According to AWS, A5.22 where applicable