

Classifications

DIN 8555	EN 12073	DIN 8556	ASME IIC SFA 5.9
MF 8-GF-C	T 20 25 5 Cu L M M 1	MSG X2-CrNiMoCu 20-25	EC 385

Characteristics

Stainless steel metal cored-wire for all positional gas shielded welding. Excellent edge blends, arc stability, penetration, weld bead aspect and minimum spatter. Improved welding speed and quality regarding solid wires of the same composition.

Microstructure: Austenite + few Ferrite

Shielding gas: Argon 98% + CO₂ 2% or Argon 100%

Field of use

For welding and cladding stainless steels of similar composition where corrosion resistance to hot sulphuric and cold hydrochloric acid is required.

Typical analysis in %

C	Mn	Si	Cr	Ni	Mo	N	Fe	Cu
0,02	2,8	0,5	20,5	24,2	5,0	0,12	balance	1,1

Typical mechanical properties

Hardness as welded: NA

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	100-200	19-28	20 max.	15-20