

# GM 209

**CHARACTERISTICS:**

GM 209 is a solid stainless steel wire which deposits radiographic quality ductile weld metal. The weld metal exhibits excellent tolerance to dilution from dissimilar and difficult-to-weld base material without hot cracking, together with high strength and very good heat and oxidation resistance. Not recommended for depositing welds to be PWHT.

**APPLICATIONS:**

- ? For joining EN 24 and EN 19A steels.
- ? Medium and high carbon hardenable steels. For e.g. tool steels, shafts, gear teeth, free cutting steels.
- ? Dissimilar joints between stainless and high carbon steels.
- ? Buffer layer prior to hardfacing with chromium carbide deposits, surfacing of metal-to-metal wear areas, hot working tools.

**CORROSION RESISTANCE:**

Good resistance to sulphurous gases at high temperature. Good resistance to wet corrosion upto approximately 300 o C.

**MECHANICAL PROPERTIES (RANGE)**

<b>UTS (Mpa)</b>	<b>Elongation (%) (L=4D)</b>
700 Min	22 Min

**SHIELDING GAS:** Ar + 2 % O<sub>2</sub> , 16-21 l/min

**WELDING CURRENT:** DC (-)

**PACKING DATA:**

<b>SIZE (mm)</b>	<b>Weight of the spool (Dia. of spool: 300mm layer to layer winding) KG (approx)</b>
0.80	12.50
1.00	12.50
1.20	12.50
1.60	12.50

