

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)

| UTS (Mpa) | Elongation (%) (L=4D) |
|--------------|--------------------------|
| 700 Min | 22 Min |

SHIELDING GAS: Ar + 2 % O₂ , 16-21 l/min

WELDING CURRENT: DC (-)

PACKING DATA:

| SIZE (mm) | Weight of the spool (Dia. of spool: 300mm layer to layer winding) KG (approx) |
|--------------|---|
| 0.80 | 12.50 |
| 1.00 | 12.50 |
| 1.20 | 12.50 |
| 1.60 | 12.50 |

