

# Stainless Steel Flux Cored Wire

## Welding Notes

Unique characteristics:

1. Stainless steel flux cored wire has deposition rate of 2~4 times of covered electrode.  
The deposition efficiency is about 90%.
2. Easier adjustment of welding parameters than solid wire.
3. Minimal welding spatter produced, easy slag removal and good bead appearance.
4. High arc stability, easy to pass RT examination.

### 1. Shielding Gas

CO<sub>2</sub> or Ar + 20~25% CO<sub>2</sub> mixed gas, depending on wire classification.

Proper flow rate: 20~25 L/min.

### 2. Wire Extension

- a. Wire diameter 0.9 mm: 15~20 mm

Wire diameter 1.2 & 1.6 mm: 15~25 mm

- b. Improper extension will cause improper shielding and result blow hole, incomplete fusion and other welding defects.
- c. For self shield type, please refer to individual product features.

### 3. Wind protection

Proper shelter for outdoor welding and proper ventilation & air flow exchange for indoor welding.

### 4. Welding Fumes

Users must observe safety regulations and warning signs while follow proper precautionary procedures.

### 5. Welding Wire Storage Requirements

Good ventilation storage area for unopened welding wire, plastic bag covered with desiccant for opened but unfinished welding wire.

## 6. Welding parameter and Deposition rate (reference data)

wire dia. (mm)	welding current (A)	welding voltage (V)	deposition rate (Kg/hr)	extension (mm)
1.2	150	24~26	2.3	15~25
	180	25~27	3.0	
	200	26~28	3.6	
	220	27~29	4.2	
	250	28~30	4.8	
1.6	200	28~30	3.0	
	220	29~31	3.6	
	240	29~31	3.9	
	280	31~33	5.0	
	300	31~34	5.5	

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