

## Product Assortment

Grade	Approvals	Grade	Approval
308LT0-1/308LT0-4 308LT1-1/308LT1-4	AWS,ASME, ABS,CWB AWS, ASME, ABS,CWB	316LT0-1/316LT0-4 316LT1-1/316LT1-4	AWS, ASME, ABS,CWB AWS, ASME,CWB
308T0-1/308T0-4 308T1-1/308T1-4	AWS, ASME, AWS, ASME,	317LT0-1/317LT0-4 317LT1-1/317LT1-4	AWS, ASME, ABS AWS, ASME
309LT0-1/309LT0-4 309LT1-1/309LT1-4	AWS, ASME, ABS,CWB AWS, ASME, CWB	347T0-1/347T0-4 347T1-1/347T1-4	AWS, ASME AWS, ASME
312T0-1/312T0-4 312T1-1/312T1-4	AWS, ASME AWS, ASME	2209T0-1/2209T0-4	AWS, ASME

## Standard Sizes and Packages

Standard Sizes: .035, .045, 1/16 inch

Standard Packages: 25 lb plastic spools with future conversion to 33 lb Wire Basket Spools

*Additional sizes or package forms may be available by contacting Sandvik Steel*

## Working Data

**Powersource-** Conventional MIG constant voltage power source

**Shielding Gas-** 100% CO<sub>2</sub> or Argon with a minimum of 20% CO<sub>2</sub> mixtures

**Gas Flow-** 35 CFH typical

**Current Range-**

Flat Position	Amp Range	Volt Range	Starting Amps/Volts
.035	70-160	22-28	150/27
.045	90-225	22-32	200/29
1/16	175-350	24-37	260/31
All Position			
.045	125-175	21-26	155/24

*Current range data is valid for all shielding gases. Starting parameters is for spray transfer and may vary according to equipment.*

**Polarity-** DCEP

**Technique-** Forehand or backhand technique may be used

**Stickout-** 3/4-1 inch. *Care should be taken to avoid too tight an arc.*

**Travel Speeds -** Care should be taken to avoid excessive travel speeds to avoid trapping slag particularly in narrow grooves. Standard travel speeds are in the range of 14-18 IPM.

**Storage-** Sandvik Flux Cored Electrodes, typical of FCE consumables, will absorb moisture if left exposed to the atmosphere, once the vacuum foil seal has been broken. It is recommended that opened spools be stored in a dry place

## Technical Support

For Technical Support for these or any other Sandvik Welding Products call our Welding Hotline at 1-800-781-9449.

Ask for publication S2330-US for our complete Sandvik Welding Products Assortment Catalog

## Contact Information

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