Maximum Versatility Austenitic Stainless Steel Electrodes and Wires

Ideally suited for welding AISI 309 stainless steel to itself and for welding 300 Series stainless steels to carbon steels.

Superior Advantages

- Crack-resistant due to a high Ferrite Number (FN)
- High heat resistance – in-service temperatures up to 1,000°F (538°C)

Applications

- Pipelines
- Storage tanks and valves
- Hydroelectric components
- Stainless steel to carbon steel

Certanium® Alloys

706 Electrode

Tensile Strength: 101,000 PSI
Hardness: Rc 22, work hardens to Rc 45
Elongation: 34%
Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	65 – 100	**P12785**	10
1/8	110 – 150	**P12775**	10
5/32	160 – 200	**P12675**	10
3/16	225 – 270	**P12665**	10
1/4	250 – 350	**P12961**	10

706FC MIG Wire

Tensile Strength: 95,000 PSI
Yield Strength: 73,000 PSI
Elongation: 38%
Gas: None

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.045	**P19535**	10
.045	**P19557**	33
1/16	**P19543**	25

Cronatron Alloys

329M MIG Wire

Tensile Strength: 95,000 PSI
Yield Strength: 76,500 PSI
Elongation: 33%
Gas: 90% He, 7.5% Ar, 2.5% CO_2 or 98% Ar, 2% O_2

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.035	**CW3503**	10
.035	**CW3504**	25
.045	**CW3505**	10
.062	**CW3506**	25

329M-FC MIG Wire

Tensile Strength: 95,000 PSI
Yield Strength: 76,500 PSI
Elongation: 33%
Gas: 75% Ar, 25% CO_2

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.035	**CW3501**	10
.035	**CW5133**	33
.045	**CW3502**	10
.045	**CW5134**	25

Other Austenitic Stainless Steel Electrodes and Wires

High resistance to heat and corrosion with high-impact and high-strength characteristics.

Superior Advantages

- Extremely resistant to highly-corrosive acids
- High temperature applications up to1,600°F (871°C)
- Excellent operating characteristics

Applications

- Severe service conditions where chemicals and acids are present
- Paper manufacturing equipment
- Food and chemical processing equipment

Certanium® Alloys

710 Electrode

Tensile Strength: 89,000 PSI
Yield Strength: 73,000 PSI
Hardness: 21 HRC, as welded
Elongation: 41%
Polarity: AC or DC Reverse

Dia. (Inches)	Amps (Flat or Overhead)	Amps (Vertical)	Part No.	Pkg. Qty. (Lbs.)
3/32	40 – 80	30 – 70	**P12896**	5
1/8	70 – 110	60 – 100	**P12901**	5
5/32	90 – 150	80 – 140	**P12255**	5

Cronatron Alloys

377 Electrode

High Temperature
Tensile Strength: 95,000 PSI
Hardness: 190 BHN
Elongation: 50%
Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	40 – 70	**CW1071**	5
1/8	50 – 100	**CW1070**	5
5/32	125 – 160	**CW1069**	5

Specialty Alloys

For Use on Carpenter 20 and Alloy 20 Stainless

3990 Electrode

Tensile Strength: 84,000 PSI
Hardness: Rb 210
Elongation: 48%
Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	50 – 70	**CW1845**	5
1/8	85 – 120	**CW1844**	5
5/32	115 – 140	**CW1843**	5

3990T TIG Wire

Tensile Strength: 84,000 PSI
Hardness: Rb 210
Elongation: 48%
Polarity: DC Straight
Gas: 100% Ar

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/16 x 36	**CW1974**	2
3/32 x 36	**CW1975**	2