



MIG 20/10T

Old reference: MIG 321

Classification

ISO 14343-A : G Z 19 9 Ti
 AWS A5.9 : ER321

Material N° : 1.4541

Description & Applications

Solid wire for joining of stabilised stainless steels (321...) or low carbon content stainless steels (304L...). Good inter-granular corrosion resistance.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Ti	P	S	Fe
0.03	0.5	1.5	18.0	10.5	0.2	0.1	0.5	<0.03	<0.02	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
460	630	35	+20°C 110

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar + 2%CO ₂ Ar + 1%O ₂ 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

Ind.10



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