

Stainless Steel Flux Cored Wire Welding Parameters

TYPICAL WELDING PARAMETERS FOR STAINLESS STEEL FLUX CORED												
Diameter	.035" 0.9mm				.045" 1.14mm				1/16" 1.6mm			
Amperage	100	120	140	170	130	165	190	220	170	210	250	300
Voltage	23	23	25	26	25	26	28	30	25	27	28	29
Wire Feed Speed in/min	265	315	405	530	227	341	445	567	154	193	243	321
Deposition Rate lbs/hr	2.9	3.4	4.6	5.7	4.25	6.14	8.08	10.24	5.34	6.89	8.57	11.43
% Efficiency	83.9	81.4	82.6	81.8	84.0	83.0	84.0	84.0	83.0	82.5	83.0	83.0

The ESO (Electrical Stick Out) is 1/2" - 1". DCEP (Electrode Positive) is specified. When using 75% Argon / 25% CO₂ mixture, decrease voltage by as much as 2 volts.

AWS CLASSIFICATION OF FLUX CORED WIRE

AWS A5.22

