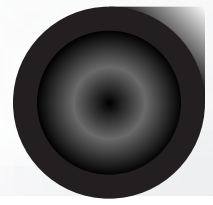


FUSION FLOW

STAINLESS STEEL FLUX CORED WIRE



Inweld
Welding Alloys & Supplies

Inweld Fusion Flow Stainless Steel Flux-Cored wires are designed for single or multiple-pass welds on many grades of austenitic stainless steels. Fusion Flow is designed to produce X-ray quality welds using 100% CO₂ or a mixed gas such as 75-80% argon plus 20-25% CO₂. Fusion Flow has excellent deposition efficiency when used in the flat position on fillet welds of medium and thick plates. The all-position (AP) wires exhibit excellent deposition efficiency in any position. Fusion Flow operates well over the widest range of amperage settings when compared to any competitive brand.

Inweld Fusion Flow stainless steel flux-cored wires are manufactured using a stainless steel sheath that contains a precise balance of elements in a matrix of flux. This allows all specifications of Fusion Flow to attain the proper ferrite level as well as welding characteristics such as low spatter, excellent bead shape and a self-peeling slag. The proper ferrite level is necessary to reduce the tendency to cracking or fissuring in austenitic stainless steels. Ferrite also increases overall weld metal strength.

Available in: 0.035", 0.045" and 1/16" on 10 and 25Lb. spools. All-Position wires are available in 0.045

Advantages include:

- * X-Ray Quality Welds
- * High Deposition Efficiency
- * Resistance to Cracking or Fissuring
- * Low Spatter and Self-Removing Slag
- * Widest Operating Ranges Using Standard MIG Equipment
- * Available in all-Position as Well as Open-Arc Variations
- * Competitive Pricing

308LT1-1/-4							Used extensively in the fabrication of stainless steel structures, pressure vessels, tanks used in dairy, pulp & paper, textile dyeing, refinery and chemical equipment.	
C	Mn	Si	Cr	Ni	Mo		Tensile	Elongation
0.03	1.87	0.75	19.50	10.30	0.50		88,500 psi	36%

308HT1-1/-4							Used extensively in the fabrication of stainless steel structures, pressure vessels, tanks used in food processing, chemical, refinery and restaurant equipment. Where a higher carbon content is needed.	
C	Mn	Si	Cr	Ni	Mo		Tensile	Elongation
0.05	1.87	0.75	19.50	10.30	0.50		88,500 psi	36%

309LT1-1/-4							Used extensively in the fabrication of stainless steel automobile muffler and exhaust systems made of AISI stainless types 409 and 436.	
C	Mn	Si	Cr	Ni	Mo		Tensile	Elongation
0.03	1.57	0.48	23.95	12.40	0.50		81,500 psi	40%

316LT1-1/-4							Used extensively in the fabrication of 18% Cr 12% Ni 2% Mo stainless steel structures, pressure vessels, tanks in dairy, pulp and paper, textile dyeing, refinery and chemical equipment.	
C	Mn	Si	Cr	Ni	Mo		Tensile	Elongation
0.03	1.85	0.75	18.70	11.40	2.50		90,000 psi	36%

316HT1-1/-4							Used extensively in the fabrication of stainless steel structures, pressure vessels, tanks used in food processing, chemical, refinery, photographic and restaurant industries.	
C	Mn	Si	Cr	Ni	Mo		Tensile	Elongation
0.05	1.47	0.60	18.40	11.50	2.50		88,500 psi	37%

317LT1-1/-4							Used extensively in the fabrication of AISI type 317 stainless steel structures, pressure vessels, tanks used in dairy, pulp & paper, textile dyeing, refinery and chemical equipment.	
C	Mn	Si	Cr	Ni	Mo		Tensile	Elongation
0.03	1.85	0.75	18.70	13.0	3.5		88,500 psi	33%

347T1-1/-4							Used extensively in the fabrication of AISI types 321 and 347 stainless steel structures, pressure vessels, tanks used in dairy, pulp & paper, textile dyeing, refinery and chemical equipment.	
C	Mn	Si	Cr	Ni	Mo	Cb	Tensile	Elongation
0.05	1.75	0.83	19.50	10.50	0.50	0.54	98,500 psi	34%

410T1-1/-4							Used extensively in the fabrication of 12% Cr stainless steel structures, pressure vessels, tanks used in dairy, pulp & paper, textile dyeing, refinery and chemical equipment.	
C	Mn	Si	Cr	Ni	Mo		Tensile	Elongation
0.12	0.69	0.32	13.20	0.60	0.50		82,500 psi	28%

Tested with 80% Argon + 20% CO₂ Shield Gas; All values listed are average values