Filler material in solid wire spools for MIG welding of dissimilar steels and for overlay welding of carbon and low-alloy steels. The high Chromium content generates a ferritic-austenitic structure highly resistant to hot cracking and fissuration of the weldment. The high Chromium content also provides a good resistance to high temperature oxidation up to 1050 °C.

**Typical chemical composition (%)**

<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Si</th>
<th>Cr</th>
<th>Ni</th>
<th>Mo</th>
<th>S max</th>
<th>P max</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.10</td>
<td>1.8</td>
<td>0.4</td>
<td>30.0</td>
<td>9.0</td>
<td>0.3</td>
<td>0.03</td>
<td>0.0</td>
<td>Base</td>
</tr>
</tbody>
</table>

**Typical mechanical properties of all-weld metal**

- $R_m$: 740 MPa
- $R_{p0.2}$: 520 MPa
- $A_s$: 25 %
- $K_V$: 30 J

**Operating parameters**

Shielding gas recommendations:

EN ISO 14175 M12: Argon + 2-3 %CO2 or Argon + 1-2 %O2/ 12-18 l/mn