Welding Consumables

Stainless Steel
Metal-Cored
Mild Steel
Nickel Alloy

Stainless Steel Metal-Cored Arc Welding Wire

American Wire Research, Inc.
**Stainless Steel Metal-Cored Arc Welding Wire for Engine Exhaust Systems**

**Why 400 series stainless steel for exhaust system**
- Thermal expansion coefficient is close to the material of engine
- Ti/Nb added, high temperature corrosion resistance is excellent
- Cost effectiveness

**Why Metal-type Flux-Cored**
- Higher burn-through resistance
- Good root-gap-bridging ability
- Superior crack resistance
- Faster travel speed
- Improved arc stability
- Higher flexibility of alloying composition
- Good wetting behavior
- Excellent mechanical property
- No slag, low spatter and less clean up
- Much wider welding parameters

**Welding Parameters**
- Voltage: 13 V
- Current: 130 A
- Travel Speed: 50 CPM (19IPM)
- Stick out length: 6mm (1/4”)
- Shielding Gas: 98% Ar + 2% O₂

**Stainless Steel Grades for Engine Exhaust System**
- 409, 444, 429, 309, 310S, 321, Cast Iron

**AWR stainless steel metal cored products produce a good weld bead profile with fine microstructure. As compared to our competitors:**

**Scale: 2.0 mm**

**Welding Parameters**
- Voltage: 13 V
- Current: 130 A
- Travel Speed: 50 CPM (19IPM)
- Stick out length: 6mm (1/4”)
- Shielding Gas: 98% Ar + 2% O₂

**American Wire Research, Inc.**

1005 Airbrake Avenue, Wilmerding, PA 15148
P: (412) 349-8431 • F: (412) 774-5005
Toll-Free: 1-800-250-5926
www.americanwirereasearch.com