
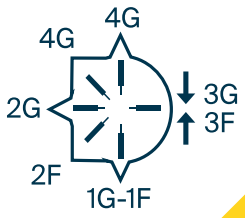

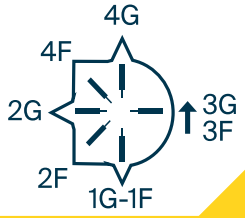

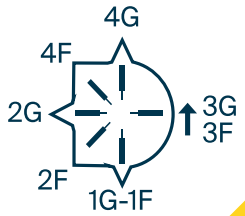
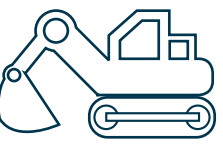
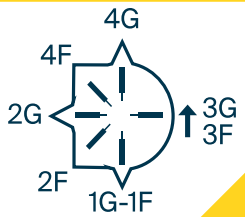
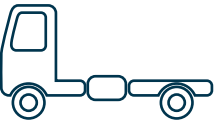
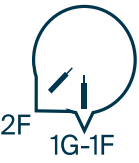

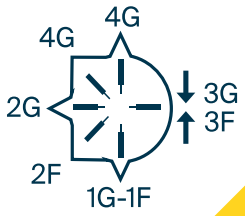
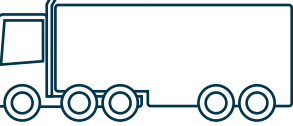
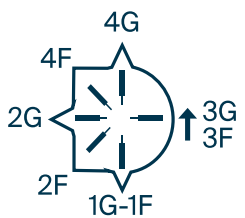
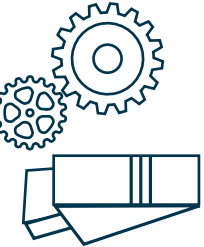
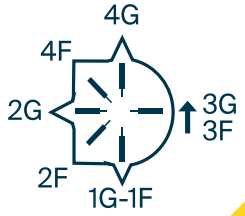
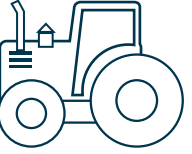

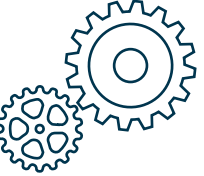
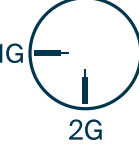




		SIZE	PART NO.	FEATURES		TYPICAL APPLICATIONS	POSITIONS
General Purpose	12P	2.5	12P25	<ul style="list-style-type: none">- Fast freezing slag.- Tolerant to dirty materials.- Exceptional vertical down capabilities.		<ul style="list-style-type: none">- General mild steel fabrication.- Repair work.- General machinery.- Agricultural steels & equipment.- Wrought iron.	
		3.2	12P32				
		4.0	12P40				
	13S	2.5	13S25	<ul style="list-style-type: none">- Very fluid slag.- Superior weld appearance.- Especially suited to vertical up welding.		<ul style="list-style-type: none">- General mild steel fabrication.- Repair work.- Trailers.	
		3.2	13S32				
		4.0	13S40				
Low Hydrogen	16TC	2.5	16TC25	<ul style="list-style-type: none">- For carbon & low alloy steels.- Easy slag removal.- Exceptional arc stability.- All positional (except vertical down).		<ul style="list-style-type: none">- Agricultural steels.- Maintenance & repair.- Structural steel, stock gates & fencing.- Earth moving equipment.	
		3.2	16TC32				
		4.0	16TC40				
		5.0	16TC50				
	77	2.5	7725	<ul style="list-style-type: none">- Exceptionally smooth.- All positional (except vertical down).- X-ray quality.		<ul style="list-style-type: none">- Earth moving equipment.- Maintenance & general repair work.- For critical weld requirements.	
		3.2	7732				
Iron Powder	24	4.0	2440	<ul style="list-style-type: none">- Excellent slag detachability.- Good edge wetting.- Positive arc starting & re-striking.- Excellent down hand & horizontal position.		<ul style="list-style-type: none">- Large structural steel & repair.- Agricultural steels & equipment.- Heavy section / thick plate.	
Stainless Steel	Staincord 309Mo-16	2.6	SC309MO26TT	<ul style="list-style-type: none">- Superior extra low carbon, all positional.- Exceptional bead appearance & weld profile.- Low spatter electrode with excellent slag detachability.		<ul style="list-style-type: none">- Suitable for welding dissimilar steels i.e. mild steel to stainless.- Applications include welding of matching 309 & 309Mo base metals, 300 & 400 series stainless steels.	
		3.2	SC309MO32TT				
	Staincord 316L-16	2.6	SC316L1626TT	<ul style="list-style-type: none">- Superior all positional (except vertical down), molybdenum bearing filler metal electrode.- Low spatter levels with excellent slag detachability.		<ul style="list-style-type: none">- Suitable for critical welding of matching type 316 & 316L steels.- Applications found on boat fittings, wine industry & dairy machinery.- Common 300 series stainless steels such as 301, 302, 304 & 304L.	
		3.2	SC316L1632TT				
	Unicord 312	3.2	UC31232TT	<ul style="list-style-type: none">- All purpose electrode ideal for welding dissimilar metal combinations.- Suitable as a buffer or intermediate layer prior to the application of hard surfacing layer.		<ul style="list-style-type: none">- High tensile (770MPa), high chromium, high strength nickel alloy steel.- For repair & maintenance of steels of unknown composition.	
Hardfacing	Abrascocord 700	3.2	HF70032	<ul style="list-style-type: none">- Hard, air hardening, martensitic type weld deposits.- Deposits are grindable.- Smooth running, air hardening martensitic Cr/Mo/V steel alloy for high loading abrasion applications.- Cannot be machined without prior heat treatment.		<ul style="list-style-type: none">- Suitable for surfacing of post hole augers, agricultural points, shares & tynes, grader & cultivator blades.- Components subject to fatigue or flexing during service.- Single layer onto mild steel typical hardness 53-56 HRC multi-layer typical hardness 55-60 HRC.	
		4.0	HF70040				
	Abrascocord 350	3.2	HF35032	<ul style="list-style-type: none">- Surfacing carbon & low alloy components.- A tough wear resistant air hardening C/Mn/Cr steel alloy which is machinable & can be readily hot forged.		<ul style="list-style-type: none">- Heavy build-up and surfacing of steel components subjected to metal-to-metal wear & compressive loading.- Typical applications track components, gears & shafts.- Single layer onto mild steel typical hardness 30-35 HRC multi-layer typical hardness 35-40 HRC.	
	Abrascocord 43	3.2	AC4332	<ul style="list-style-type: none">- Very hard chromium/niobium carbides deposits.- Hard, complex carbide/austenite deposit that is grindable only.- Deposits exhibit exceptional resistance to extreme abrasion & moderate to heavy impacts.		<ul style="list-style-type: none">- Suitable for extreme abrasion & moderate to heavy impact.- Service applications, press screws, grizzly bars, crusher hammers, ripper teeth & shovel teeth & lips.- Single layer onto mild steel typical hardness 60-65 HRC, multi-layer typical hardness 64-69 HRC.	
		4.0	AC4340				

This WIA selection chart and it's recommendations should be used merely as a guide only. Every attempt has been made to ensure the product information is correct at the time of publication. Before welding, it is recommended by WIA that the materials weldability/compatibility be confirmed by a suitably qualified welding specialist in choosing the correct welding electrode to be used. The selection chart is a reference guide for suggested welding applications. WIA accepts no liability for the products selected from this selection chart, as it is intended to be used as a guide only for selecting the correct electrode for its general application. Note: Every effort has been made to ensure that the information contained on this selection chart was correct at the time of printing. Issued 2022.