

AWS CLASSIFICATION: A5.34: 2007

ISO: TNi 6133-11/-14 AWS: ENiCrFe2T1-1/-4

DESCRIPTION

Stoody A-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO₂ or Argon/CO₂ mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications.

TYPICAL DEPOSIT CHARACTERISTICS

Tensile Strength	89.5 ksi (595 Mpa)
Yield Strength	51.0 ksi (340 Mpa)
Elongation	45%
Charpy Impact Toughness	67 ft.-lbs. (92 Joules) at -320°F (-196°C)
Lateral Expansion	46 mils (1.2mm) at -320°F (-196°C)

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	0.03
Manganese	2.5
Silicon	0.3
Chromium	15.0
Iron	1.5
Molybdenum	1.9
Niobium	1.9
Sulfur	0.003
Phosphorus	0.010
Nickel	Balance

TYPICAL APPLICATIONS

Typical applications include:

- Joining nickel-chromium-iron alloys
- Joining nickel steels
- Joining Inconel 600, 601 and Incoloy 800 to themselves or to stainless and carbon steels.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	.045 (1.2)
Amperage (DCEP)	150 – 200
Wire Feed Speed (ipm)	290 – 400
Voltage	25 – 26
Shielding Gas	75% Ar -25% CO ₂ or 100%CO ₂
Wire Extension, in (mm)	1/2 (12)

Diameter, in. (mm)	1/16 (1.6)
Amperage (DCEP)	200 – 250
Wire Feed Speed (ipm)	190 – 275
Voltage	26 – 27
Shielding Gas	75% Ar -25% CO ₂ or 100% CO ₂
Wire Extension, in (mm)	1/2 (12)

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	33# Wire Basket, LLW	11896500
1/16" (1.6mm)	33# Wire Basket, LLW	11896700

Stoody Company

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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.
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