

MF 205

SPECIAL VERTICAL POSITION ELECTRODE FOR ALL GRADES OF STAINLESS STEEL



- SUITABLE FOR VIRTUALLY ALL GRADES OF STAINLESS STEEL
- PROVIDES SUPERIOR CORROSION RESISTANCE
- UNIQUE “FAST FREEZE” COATING ENABLES VERTICAL
- UP AND DOWN WELDING
- IDEAL FOR POOR FIT JOINTS



MF-205

SPECIAL BENEFITS

- **MF 205** Corrosion-Resistant welding alloy for all grades of Stainless Steel
 - **MF 205** is ideal for poor fit up joints in all positions
 - **MF 205** provides vastly superior corrosion resistance
 - **MF 205** gives all-position ease of use
 - **MF 205** gives a controlled weld puddle allows for filling holes on stainless steels
 - **MF 205** is a solution alloy for maintenance of stainless steel users
-

OUTSTANDING PROPERTIES:

- Provides remarkable resistance to corrosion.
 - Say to in some jobs "burn through" Can be controlled when welding thin gauge sheets
 - Runs well even off tiny, portable open circuit AC welding machines
-

APPLICATIONS

- Bakeries ● Wineries ● Breweries ● Bottling Plants.
 - Chemical & Fertilizer Plants ● Dairy Farm Operations
-

MECHANICAL PROPERTIES:

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation
Impact Energy
Hardness

Maximum Value Up to:

80,000 psi (550 N/mm²)
56,000 psi (390 N/mm²)
42%
40J: -157°F (-105°C)
Brinell 209, Rockwell B96

**MF - 205 SPECIAL VERTICAL POSITION ELECTRODE
FOR STAINLESS STEEL**



MF-205

RECOMMENDED CURRENT: DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)
Minimum Amperage	35	60	90
Maximum Amperage	55	80	110

WELDING POSITIONS: All Positions

WELDING TECHNIQUES:

For vertical welding, set amperage at Maintain a angle with the electrode pointing upward. Whip the electrode quickly back and forth while moving up or down.

**MF - 205 SPECIAL VERTICAL POSITION ELECTRODE
FOR STAINLESS STEEL**

