MF 206

Titanium
And Niobium stabilized
18/8 stainless steels

- Provides Maximum Cracking/corrosion Resistance
- Controlled Silicon Content
- Gives All–position Ease Of Use
- Outstanding Versatility Welds Virtually

  "most Stabilized Like Columbium Or Titanium Type"

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MF-206

MF - 206 TITANIUM AND NIOBIUM STABILIZED 18/8 STAINLESS STEELS

SPECIAL BENEFITS

- **MF 206** ideal for virtually all grades of stainless steel
- **MF 206** is specifically suitable for food grade stainless steels
- **MF 206** provides vastly superior corrosion/crack resistance
- **MF 206** gives all-position ease of use
- **MF 206** can be used for architectural applications
- **MF 206** is good for thin stainless steel welding uses

OUTSTANDING PROPERTIES:

- Stainless steel electrode designed specifically for welding Titanium and Niobium stabilized 18/8 stainless steels
- Features "Controlled Slag Blanket" technology
- Reduces "burn through" when welding thin gauge sheets

APPLICATIONS

MF 206 (for AC & DC) is ideal for the maintenance of stainless steel equipment used in food industry

- Bakeries
- Canneries
- Dairy Farm Operations
- Display equipment
- Breweries
- Bottling Plants
- Packaging Plants
- Cookstoves
- Wineries

It is also suitable for high corrosion industries

- Chemical Plants
- Fertilizer Plants
- Refineries

Stainless Steel electrode designed specifically for welding Titanium and Niobium stabilized 18/8 stainless steels

- Excellent out of position weldability
- Control Low Carbon content help minimal cracking
- Controlled Elements content for minimusing cracking/ corrosion resistance

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MECHANICAL PROPERTIES:

Undiluted Weld Metal	**Maximum Value Up to:**
Tensile Strength	82,000 psi (560 N/mm^2)
Yield Strength	57,000 psi (370 N/mm^2)
Elongation	35%
Impact Energy	70J: 68°F (20° C), 20J: -320°F (-196°C)
Hardness	Brinell 205, Rockwell B94

RECOMMENDED CURRENT: DC Straight, DC Reverse (+) or AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	75	90
Maximum Amperage	75	110	140

WELDING POSITIONS: All positions

WELDING TECHNIQUES:

Material to be welded should be clean of all contaminants.
Maintain a short arc and use
stringer beads rather than a weave technique.

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