MF TIG 208FC

Stainless Steel 316L FC TIG - Coated With Vari-Flow Fluxing System

- A Special Stainless Steel 316L TIG Alloy coated with unique Vari-Flow Fluxing System.
- A very special TIG wire that eliminates the expense & down time associated with purging pipes with inert backing gasses.
- Easy to handle 18 inch (450mm) length. Works in multiple positions without having to bend the wire.
- Eliminate Back-Shielding / Purging – Saves Time & Cost.

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SPECIAL BENEFITS

- MF 208 is a Flux-Cored wire that saves downtime and maintenance cost in welding of Stainless Steel pipes & vessels.
- MF 208 eliminates the need for back shielding or purging using inert gas.
- MF 208 shields the backside of the root pass from destructive effects of atmospheric nitrogen & oxygen.
- MF 208 is an ideal maintenance welding wire suitable for versatile applications in Refineries, Power plants, Chemical plants or Fertilizer plants.

OUTSTANDING PROPERTIES

- MF 208 TIG rod is an extremely low carbon stainless steel Alloy with molybdenum added to provide superior corrosion resistance.
- MF 208 is well suited for welding stainless steel pipe wherever a backing ring or a purge gas is required in order to provide impurity free weldments.
- MF 208 is ideally needed, during stainless steel pipe welding in the chemical industries. chemical and petro-

APPLICATIONS

- Root pass in pipe welding to eliminate backside purging with inert gas.
- Most stainless steels, low-alloysteels and mild steels & 316 , 316L type steels
- Furtilizer Industries
- Chemical industries
- Petro-Chemical Industries

MF 208 - ROOT GARD

MF 208 FC TIG “Root Gard” provides regular penetration through the entire part of the pipe in all positions – creating excellent welds on single-sided weld joints.

RECOMMENDED FOR:

Stainless Steels, Low-Alloy Steels and Mild Steels & 316 , 316L type Steels

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MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	80,000 PSI (550 MPa)
Yield Strength	56,000 PSI (390 MPa)
Elongation	42%
Impact Energy	40J: -157ºF (-105ºC)
Hardness	Brinell 209, Rockwell B96

RECOMMENDED CURRENT: DC Straight (-)

RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3/32 (2.5)	1/8 (3.25)
Minimum Amperage	60	80
Maximum Amperage	100	120

WELDING POSITIONS: Flat, Horizontal, Vertical Up

WELDING TECHNIQUES:

Clean the weld surface carefully to remove all scale and corrosion.
Sections over 3mm should be beveled to permit complete penetration.
Clean joint surface using a stainless steel brush.

Use DC - (straight polarity), 2% thoriated tungsten electrode.

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