

FILLER METAL SELECTION TABLE FOR MILD STEEL AND ALLOY STEEL WELDING

PRODUCTS	SPECIAL	206 *FC 821066	214	220 *FC 82206	222 *FC 82206	222 SP	225 MC 82256	230	265 FC 82656	267	275	277 *FC 82776	298	M 8221	271	M 500
PROPERTIES																
Tensile strength (x 1000 psi)	85	95 (*100)	75	115 (*112)	80	80	120	122	141	120	100 (*90)	118	100	95	72	
Elongation (%)	26-40	38 (*35)	23-26	21-24 (*23)	24-28	32-36	28-32	30-35	22-27	26	38-45 (*41)	27-30	23	22-26	28	
All-position	1		2	2	2	1	2	2			2	2			1	
Badly prepared joints (mild steel)			3		3											2
Cracking resistance		1					2	2			1	2				
Dirty or oily mild steel	2		3		2	3										1
Unknown steels		3					2	1	2	2	3	3				
Unknown stainless steels		2					3	3	2	3	1	3				
High carbon steels		2					1	1		1	2	2				
Manganese steels		1							1		2					
High strength low alloy steels(T1)		2		2					2	3	1	2	1			
Cr – Mo low alloy steels				3			2	2		2	1	3	2	1		
Cast steels	1	2		3		3	2	2	1		1	2				
Galvanized steels			3		1						1					1
Heterogeneous assemblies		2					2	1		1	3	3				
Stud extraction							2	2								
Axles and shafts		2					1	1			2	2				
Band saws														1		
Frames	3			1							2					
Forklifts		2		3			2	2			1	3				

1 = Most efficient product(s)

Notes:
