

Strongweld®

Ultimate Welding Performance



Stainless Steel Flux Cored Wires



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www.strongweld.net



INDURA – a Service Oriented Technology Company

At INDURA, we have taken a serious commitment towards premium quality, preserving the environment and exercising a wide extent of social responsibility. This vision is reflected in our outstanding line card of products, designed to provide ultimate welding performance.

We appreciate your preference and we will strive to serve your requirements with a value offer that maximizes your outcome. At INDURA, we want to provide our partners with a competitive edge and establish long lasting, solid business relationships.

For over 60 years, in 12 countries, our team of excellence has made our company flourish and our clients has been the springboard for a history of achievement and success with sales over \$460M and a market valuation of \$1.5B, we are proud to keep things still at a personal level...because we care about people.

The brochures represent a small snapshot of our extensive line card. If you require special assistance, we will be there to help you...all the way

Strongweld



INDURA 309LT-1 (K-309LT)

Classification: AWS A5.22 E309LT1-1/-4a



Designed to weld dissimilar joint welds of-and-between high-strength, mild steels and low allowed QT-steels, stainless, ferritic Cr- and austenitic Cr-Ni-steels, manganese steels. Cladding for the first layer of corrosion resistant weld claddings on ferritic-perlitic steels in boiler and pressure vessel parts up to fine-grained steel S500N. Weld metal contains comparatively much more ferrite in their austenitic structure, therefore they provide better weldability together with superior heat resistance, and corrosion resistance. It is easy to use and operate with a powerful penetrating spray arc transfer, minimum spatter formation and self releasing slag.

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15-25ℓ/min)
- Mix: Ar+20% CO₂ (15-25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO ₂	0.03	0.60	1.12	23.70	13.20	14
Mix	0.03	0.75	1.20	23.90	13.20	15

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30°C	Remarks
AWS A5.22		min. 550	min. 30		
EN ISO 17633-B		min. 550	min. 25		
Example	430	560	37	45	CO ₂
	440	570	37	48	Mix

INDURA 308LT-1 (K-308LT)

Classification: AWS A5.22 E308LT1-1/-4



Tubular wire designed for MAG welding of low carbon 18%Cr-8%Ni stainless steel and used to joint austenitic stainless steel (AISI 304, 304L, 304LN, ASTM A157 Gr. C9; A320 Gr. B8C or D) The weld metal contains optimum ferrite contents in their austenitic structures, Therefore their weldability is excellent with lower crack susceptibility. It has easy slag removal, low spatter generation and good weld soundness of weld-metal.

Strongweld



INDURA 316LT-1 (K-316LT)

Classification: AWS A5.22 E-316LT1-1/-4



Flux Cored Wire designed for MAG welding of low carbon 18%Cr-12%Ni-2%Mo stainless steels has low carbon content which gives good resistance to most types of corrosion of the weld metal (AISI 316L, 316Ti) INDURA 308LT-1 is a titania type of flux cored wire for all-position welding and the weld metal contains optimum ferrite contents in their austenitic structures, therefore their weldability is excellent with lower crack susceptibility. This wire has self-detaching slag, spray-like arc transfer, excellent weldability and increased creep resistance at elevated temperature.

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15-25ℓ/min)
- Mix: Ar+20% CO₂ (15-25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO ₂	0.03	0.60	1.15	20.30	10.50	9
Mix	0.03	0.65	1.25	20.40	10.50	10

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -40°C	Remarks
AWS A5.22		min. 520	min. 35		
EN ISO 17633-B		min. 520	min. 30		
Example	440	570	39	65	CO ₂
	450	580	38	63	Mix

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15-25ℓ/min)
- Mix: Ar+20% CO₂ (15-25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	Cr	Ni	FN
CO ₂	0.03	0.60	1.12	23.70	13.20	14
Mix	0.03	0.75	1.20	23.90	13.20	15

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30°C	Remarks
AWS A5.22		min. 550	min. 30		
EN ISO 17633-B		min. 550	min. 25		
Example	430	560	37	45	CO ₂
	440	570	37	48	Mix