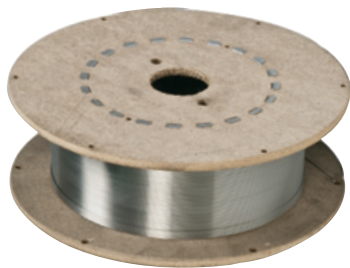


Technical Data Sheet

340M MIG Wire



Cronatron™
A LAWSON BRAND



Overview

The ultimate thermoreactive welding alloy for specific use with 400 Series stainless steels. This unique alloy system will respond to heat-treatment and retain its superior mechanical properties without cracking. The mechanical properties of the as-deposited weld metal are similar to that of most 400 Series stainless steels.

Features/Benefits

- Weld deposits are tough, low carbon martensitic structure; smooth, dense and free of porosity and cracks
- Excellent for joining and overlaying 400 Series martensitic stainless steels
- Resistant to moderate corrosion and heat scaling up to 1,200°F (650°C)
- Low coefficient of friction makes 340M ideal for surface buildup
- Ideally suited for high-temperature applications, 800°F (425°C)
- Excellent machinability on all base metals

Applications

- 400 Series stainless steels
- Turbine blades
- Catalytic converters
- Cams
- Tool steel repairs
- Mixer blades
- Augers

Method of Application

MIG welding machine

Identification

Labeled wire spool

Directions for Use

Remove all foreign materials, fatigued metal and sharp edges from base metal. Preheat base metal to 400°F to 600°F (205°C to 315°C). Use DC reverse polarity with 98% Ar, 2% O₂ shielding gas. Weld with stringer beads only, holding a short arc.

Technical Specifications

Tensile Strength: 140,000 PSI (965 MPa)
Hardness: Rc 40
Elongation: 25%
Gas: 98% Ar, 2% O₂

Technical Tips

For typical operating parameters refer to Product Information Report – Typical Operating Parameters