



QUALITY ENGINEERED ALLOYS

Magnum 9800 Ni2

Low Alloy Steel Electrode

*Flux Cored Arc Welding
*Single and Multi-Pass Welding

*External Gas Shielding
*High Tensile 105,000 PSI

DESCRIPTION:

Magnum N2 is a gas shielded, flux cored electrode designed for all position single and multi-pass welding of 90,000 psi minimum steels subject to heat treatment. Steels include ASTM A203 A352 and cast B and B+ steels.

ALLOY TYPE: Hardfacing

TYPICAL APPLICATIONS

Steels Subject to Heat Treatment Offshore Platforms
Earth Moving Equipment Leg Assemblies

OPERATIONAL CHARACTERISTICS/WELDING PARAMETERS

POSITION	DIAMETER	SHIELDING GAS	AMPS	VOLTS	STICKOUT	WFS
All Positions	1/16	CO ₂	225-350	22-29	3/4" – 1"	220-300
Flat	3/32	CO ₂	300-550	26-34	3/4" – 1 1/2"	195-210