

FILLER METAL SELECTION TABLE FOR MILD STEEL AND ALLOY STEEL WELDING

PRODUCTS PROPERTIES	SPECIAL	21	206 TFC 8206G	214	220 TFC 8206G	222 227 SP	225 M 8226G	230	245 TFC 8206G	275	277 TFC 8276G	298	M 8221	271	M 500	STD-XTRACT
	Tensile strength (x 1000 psi)	85	80	95 (*100)	75	115 (*112)	80	80	120	122 (*122)	120	100 (*90)	118	100	95	72
Elongation (%)	26-40	26	38 (*35)	23-26 (*23)	21-24 (*23)	24-28	32-36	28-32	30-35 (*22)	26	38-45 (*41)	27-30	23	22-26	28	30-35
All-position	1	2	2	2	2	2	1	2	2	2	2	2		1		2
Badly prepared joints (mild steel)		1		3		3										2
Cracking resistance			1					2	2		1	2				
Dirty or oily mild steel	2	1		3		2	3									1
Unknown steels			3					2	1	2	3	3				
Unknown stainless steels			2					3	3		1	3				
High carbon steels			2					1	1	1	2	2				
Manganese steels			1								2					
High strength low alloy steels(T1)			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	2				
Galvanized steels		2		3		1										1
Heterogeneous assemblies			2					2	1	1	3	3				
Stud extraction								2	2							1
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)

Note:

This table is not exhaustive; other products may be suitable for certain applications and/or characteristic. Consult the **FSH Welding Canada** Technical Department