



Midalloy

ELECTROSLAG

SUBMERGED ARC

STRIP SURFACING

S P E C I F I C A T I O N S

IMPORTANT REMINDER

The data contained in this bulletin are intended for general information only, and not for specification purposes.

Applications suggested for these alloys are made to permit you to make your own evaluation and decision, and are not to be construed as either express or implied warranties of fitness for these or other applications.

All analyses should be considered as typical or average values, and are minimum or maximum only where indicated. They are not intended for specification purposes.

PROTECT YOURSELF AND OTHERS - Users should read and follow all recommended guidance on health and safety from their employer, the supplier, the manufacturer, and government authorities. These, at a minimum include the Warning Labels on the products and the Material Safety Data Sheets ("MSDS"). The MSDS and additional safety information may be found on materials or links at www.midalloy.com.

STRIP SURFACING – SPECIFICATIONS

SUBMERGED ARC

TYPE DEPOSIT	STRIP	FLUX	LAYER	AMPS	VOLTS	IPM	BUILD UP THICKNESS	DEPOSIT CHEMISTRY										
								C	Si	Mn	Cr	Ni	Mo	Fe	Cb	Other	Ferrite Schaeffler	
MILD STEEL	Fe	S46T	1	1275	23	5.9	.183		.08	.4	.9	–	–	–	bal.	–	–	–
	Fe	S46T	2	1275	23	5.9	.175		.05	.4	.8	–	–	–	bal.	–	–	–
304	309L	INT 101	1	750	24	5.5	.157		.06	.8	1.4	19.5	10.4	–	–	–	–	6.5%
	309L	INT 101	1	1100	24	7.1	.165		.06	.8	1.5	19.5	10.5	–	–	–	–	6.0%
304L	309L	INT 101	1	750	24	5.5	.157		.06	.8	1.4	19.5	10.4	–	–	–	–	6.5%
	308L	INT 101	2	750	24	4.7	.165		.03	.8	1.0	19.2	10.2	–	–	–	–	8.5%
	309L	INT 101	1	1200	24	7.9	.173		.07	.8	1.5	19.0	10.0	–	–	–	–	6.0%
	308L	INT 101	2	1200	24	7.9	.157		.04	.7	1.0	19.0	10.0	–	–	–	–	7.0%
316L	309L	INT 101	1	750	24	5.9	.149		.06	.9	1.4	19.4	10.3	–	–	–	–	–
	316L	INT 101	2	750	24	5.1	.157		.03	.7	1.4	17.7	11.5	2.1	–	–	–	6.5%
347	309LCb	INT 109	1	750	24	6.3	.130		.06	.9	1.8	18.5	9.0	–	–	.30	–	8.0%
	347	INT 109	2	750	24	5.5	.157		.03	.8	1.4	19.8	9.6	–	–	.50	–	11.0%
NiCr-3 (FM 82) (.025 Max C.)	NiCr-3	NFT 201	1	750	26	4.3	.197		.41	.34	3.6	17.4	bal.	–	11.6	2.04	Ti .05	–
	NiCr-3	NFT 201	2	750	26	4.3	.185		.017	.32	3.6	19.6	bal.	–	2.9	2.20	Ti .08	–
NiCrMo-3 (FM 625) (.015 Max C.)	NiCrMo-3	NFT 201	1	760	24	4.3	.181		.04	.26	.98	18.9	bal.	8.2	14.1	2.46	–	–
	NiCrMo-3	NFT 201	2	760	24	4.3	.173		.02	.24	1.05	20.9	bal.	9.1	3.6	2.48	–	–
NiCu-7 (FM 60)	NiCu-7	NiCuT	1	900	26	5.5	.200		–	1.0	2.7	–	–	–	20	–	–	–
	NiCu-7	NiCuT	2	900	26	7.1	.149		.02	1.0	3.0	–	62	–	10	–	Cu 26	–

ELECTROSLAG-(RES)

304L	309L	EST 122	1	1250	24	6.5	.200		.03	.62	1.43	19.6	10.0	–	–	–	–	8.0%
347	309LCb	EST 122	1	1250	24	6.5	.200		.031	.52	1.27	18.7	10.1	–	–	.49	–	–
NiCr-3 (FM 82)	NiCr-3	EST 201	1	1100	24	6.3	.160		.19	.37	2.69	17.5	bal.	–	15.0	–	–	–
	NiCr-3	EST 201	2	1100	24	4.7	.200		.02	.32	2.84	19.1	bal.	–	4.4	–	–	–
NiCrMo-3 (FM 625)	NiCrMo-3	EST 201	1	1125	24	6.1	.165		.36	.30	.30	18.6	58.9	7.9	12.4	–	–	–
	NiCrMo-3	EST 201	2	1125	24	4.7	.200		.24	.21	.10	21.0	62.9	9.6	3.0	–	–	–
	NiCrMo-3	EST 201	3	1125	24	6.1	.165		.24	.21	.09	21.1	bal.	9.8	1.1	–	–	–
NiCu-7 (FM 60)	NiCu-7	EST 201	1	1000	24	6.0	.200		.035	.50	2.6	–	bal.	–	10.0	–	Cu 25.0	–
	NiCu-7	EST 201	2	1000	24	6.0	.200		.02	.50	2.8	–	bal.	–	3.0	–	Cu 28.0	–

- All information based on 60mm X .5mm strip
- All deposit chemistries based on STRIP/FLUX combination
- Base Material 0.2% CARBON

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