

**AWS CLASSIFICATION OF FLUX CORED WIRE      STAINLESS STEEL FLUX CORED WIRE WELDING PARAMETERS**

TYPICAL WELDING PARAMETERS FOR STAINLESS STEEL FLUX CORED												
Diameter	0.35" 0.9mm			.045" 1.2mm			1/16" 1.6mm					
	Amperage	100	120	140	170	130	165	190	220	170	210	250
Voltage	23	23	25	26	25	26	28	30	25	27	28	29
Wire Feed Speed in/min	265	315	405	530	227	341	445	567	154	193	243	321
Deposition Rate lbs/hr	2.9	3.4	4.6	5.7	4.25	6.14	8.08	10.24	5.34	6.89	8.57	11.43
% Efficiency	83.9	81.4	82.6	81.8	84	83	84	84	83	82.5	83	83

