



Manufacturers of Custom Welding Lines for Resale  
[www.selectrode.com](http://www.selectrode.com)

# SELECTRODE 7249 Flux Cored MIG

## INTERNATIONAL CLASSIFICATIONS

AWS A5.22 E307T-1, E307T1-4

## FEATURES & APPLICATIONS

7249 is a gas-shielded, flux cored, stainless steel electrode designed to weld in all positions. It has a nominal weld metal composition of 19% Cr, 10% Ni, 4% Mn, 1% Mo and a carbon content of 0.08%. The relatively high manganese content helps reduce the chances of weld metal cracking in dissimilar metal welding. It is designed for use with 100% carbon dioxide or a blend of 75-80% argon/balance carbon dioxide. Shielding gas mixtures with more than 75-80% Argon are not recommended. 7249 provides superb performance characteristics in all positions, using either CO<sub>2</sub> or argon + 20-25% CO<sub>2</sub> shielding gas. Flat, well washed beads can be achieved with minimal weaving. Spatter is very low and slag peeling is excellent, minimizing cleanup. 7249 is an excellent choice for joining difficult to weld steels, such as armor plate and hardenable steels, and for dissimilar metal joints, such as austenitic manganese steels to carbon steel forgings and castings.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Si	Cr	Mo	P	S	Ni	Fe
0.07	4.20	0.70	19.40	1.10	0.011	0.01	10.0	Bal

## TYPICAL MECHANICAL PROPERTIES (CO<sub>2</sub>)

**Undiluted Weld Metal**

**Maximum Value Up to:**

Tensile Strength	90,000 PSI (621 MPa)
Yield Strength	59,000 PSI (407MPa)
Elongation	39%

\*Strength levels will be slightly higher w/Ar+20-25% CO<sub>2</sub>

## WELDING CURRENT & INSTRUCTIONS

### Recommended Current: DCEP

Diameter	Amperage	Voltage	Wire Speed (ipm)	Stick Out
.035"(0.9mm)	150-165	26-27	500-600	5/8" – 3/4"
.045"(1.14mm)	160-200	26-28	300-425	5/8" – 3/4"
1/16"(1.57mm)	215-250	27-28	195-240	3/4" – 1"

### Welding Positions: All