



Electrode Selection Chart *austarc*[®] premium welding electrodes

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PRODUCT GROUP	SIZE	PART No.#	DESCRIPTION	TYPICAL APPLICATIONS	ELECTRODE POSITION	
GENERAL PURPOSE	Austarc 12P	2.0	12P20	<ul style="list-style-type: none"> Smooth running easy starting electrode with fast freezing slag action. Exceptional all positional electrode, exceptional vertical up capabilities. Superb arc starting and striking characteristics, tolerant to dirty materials eg. rust etc. Ideal for the "one electrode" workshop & joints with poor fit-up. Especially suited to galvanised steel/tubing/sheetmetals etc. 	<ul style="list-style-type: none"> Bin frames, fences, trailers, agricultural equipment. All general mild steel fabrication and repair work. Wrought iron, square/rectangular tubing R/H sections. Storage bins, tubular sections, general machinery. 	
		2.5	12P25	<ul style="list-style-type: none"> General purpose smooth running, easy starting electrode with a very fluid slag. Versatile all positional electrode especially suited for vertical up welding. Superior weld appearance and easy to use blue and white striped electrode. Suitable for all galvanised steels including fencing, pipes, RHS, sheet metal and structural steels. 	<ul style="list-style-type: none"> Trailers, duct work, feed bins, silos, gates, fences and stock yards. General machinery and joining light steel to heavy sections. All agricultural machinery/components. 	
		3.2	12P32			
		4.0	12P40			
	Austarc 13S	2.0	13S20	<ul style="list-style-type: none"> Unique twin coated low hydrogen all positional (except vertical down) electrode that sets the standard. Applications include carbon steel, high tensile steels, hard to weld steels, and steels of unknown composition. Very fluid slag action with the glassy slag easily removed from weld metal. A great all rounder electrode with exceptional arc stability. X-ray quality. 	<ul style="list-style-type: none"> Suitable for "buttering layers"/ build-up welding repairs. High strength welds on agricultural steels, grouser bars and stick rakes. Ideal for maintenance and repairs of all structural steel, stock grates (railway iron) and stock fencing. Earth moving equipment & agricultural implements. 	
		2.5	13S25			
		3.2	13S32			
		4.0	13S40			
		5.0	13S50			
	IRON POWDER	Austarc 24	3.2	2432	<ul style="list-style-type: none"> Smooth running all positional (except vertical down) hydrogen controlled. Exceptionally smooth basic coated iron powder electrode. Performs like a general purpose electrode incorporating the weld metal strength of a hydrogen controlled electrode. X-ray quality welds with sub zero temperature impacts. 	<ul style="list-style-type: none"> Excellent fillet welds in the down hand and horizontal position using the touch welding technique. Heavy section/thick plate, large structural steel type welding jobs and repair work. Trailer bodies, tanks, frames, rolling stock, build-up repairs and farm machinery.
4.0			2440			
5.0			2450			
LOW HYDROGEN	Austarc 16TC	2.5	16TC25	<ul style="list-style-type: none"> Pipe welding. Earth moving equipment. Maintenance and general repair work. Suitable for critical welding requirements. 		
		3.2	16TC32			
		4.0	16TC40			
		5.0	16TC50			
	Austarc 77	2.5	7725	<ul style="list-style-type: none"> Superior extra low carbon, all positional (except vertical down), smooth arc action rutile type electrode. Moisture resistant coated electrode with exceptional bead appearance and weld profile. Low spatter electrode with excellent slag detachability. 	<ul style="list-style-type: none"> Extra low carbon weld deposits. Suitable for critical welding of matching type 316 and 316L steels. Applications found on boat fittings, wine industry and dairy machinery. General welding of ferritic stainless steel alloys such as 409, 444 and 3Cr12. Common 300 series stainless steels such as 301, 302, 304 and 304L. 	
		3.2	7732			
		4.0	7740			
		5.0	7750			
STAINLESS STEEL	Staincrod 309Mo-16	2.5	SC309MO25	<ul style="list-style-type: none"> High tensile (770MPa), high chromium high strength nickel alloy steel specially formulated for joining all alloy steels and irons, tool and die maintenance. For repair and maintenance of steels of unknown composition. Also suitable as a buffer or intermediate layer prior to the application of hard surfacing. 		
		3.2	SC309MO32			
	Staincrod 316L-16	2.0	SC31620	<ul style="list-style-type: none"> Pure nickel, graphite coated AC/DC electrode producing a ductile, fully machinable weld deposit. Easy striking, smooth running with low penetration and spatter levels. High nickel electrode for repair and reclamation work. Lower strength welding of cast irons, fully machinable deposits with good wetting action. 		
		2.5	SC31625			
		3.2	SC31632			
	Unicord 312	2.5	UC31225	<ul style="list-style-type: none"> High nickel, graphite coated AC/DC electrode for higher strength welds in grey and ductile metals. Recommended for repair and reclamation of all standard grades of grey cast irons, malleable iron, austenitic cast iron and some grades of meehanite cast iron. Machinable Nickel-Iron deposit for high strength ductile and SG (spheroidal graphite) irons. Fully machinable weld deposits. 		
3.2		UC31232				
SUPERCAST Ni	3.2	SNi32	<ul style="list-style-type: none"> Hard, air hardening, martensitic type weld deposits. Deposits are grindable. Smooth running, air hardening martensitic Cr/Mo/V steel alloy for high loading abrasion applications. Cannot be machined without prior heat treatment. 			
	3.2	SNiFe32				
HARD FACING	Abrascrod 700	3.2	HF70032	<ul style="list-style-type: none"> Very hard chromium/nibium carbides deposits. Hard, complex carbide/austenite deposit that is grindable only. Deposits exhibit exceptional resistance to extreme abrasion and moderate to heavy impacts. 		
		4.0	HF70040			
		5.0	HF70050			
	Abrascrod 350	3.2	HF35032	<ul style="list-style-type: none"> Suitable for extreme abrasion and moderate to heavy impact. Service applications, press screws, grizzly bars, crusher hammers, ripper teeth and shovel teeth and lips. 		
		4.0	HF35040			
	Abrascrod 43	3.2	AC4332	<ul style="list-style-type: none"> Heavy build-up and surfacing of steel components subjected to metal-to-metal wear and compressive loading. Typical applications track components, gears and shafts. 		
4.0		AC4340				

This WIA selection chart and its recommendations should be used merely as a guide only. Every attempt has been made to ensure the product information is correct at the time of publication. Before welding, it is recommended by WIA that the materials weldability/compatibility be confirmed by a suitably qualified welding specialist in choosing the correct welding electrode to be used. The selection chart is a reference guide for suggested welding applications. WIA accepts no liability for the products selected from this selection chart, as it is intended to be used as a guide only for selecting the correct electrode for its general application. Note: Every effort has been made to ensure that the information contained on this selection chart was correct at the time of printing. Issued 08.