

# Technical Data Sheet

## 211M-FC MIG Wire



**Cronatron™**  
A LAWSON BRAND



### Overview

Overwhelmingly the best gas metal arc welding product for high weld metal deposition repairs of cast iron. Formulated for use on Meehanite, gray and ductile cast irons. This highly-versatile flux-cored MIG wire will minimize downtime on all cast iron repairs.

### Features/Benefits

- This gas metal arc flux-cored wire will produce a 97% deposition efficiency, which is 30% faster than shielded metal arc welding
- 211M-FC MIG Wire will minimize the tendency for heat-affected zone cracking
- Primarily formulated for building up worn cast iron components and is also suitable for joining cast iron to itself, to steels and to stainless steels
- All-position welding can be performed with 211M-FC without dismantling equipment

### Applications

- Castings and molds
- Cylinder blocks
- Driveshaft overlay
- Exhaust systems
- Bearing housings
- Cylinder heads
- Off-road equipment
- Transmission cases
- Pump impellers
- Hydraulic rams
- Manifolds
- Gears

### Method of Application

MIG welder; DC reverse polarity

### Identification

Layer level wound, labeled spooled wire

### Directions for Use

Use DC electrode positive (reverse polarity) with 98% Ar, 2% O<sub>2</sub> as the shielding gas. For best results, set wire amperage and adjust voltage for the smoothest operation. Some types of cast iron may need to be preheated prior to welding.

### Technical Specifications

Tensile Strength: 74,000 PSI (510 MPa) minimum  
Elongation: 12%  
Hardness: Rb 87  
Gas: 98% Ar, 2% O<sub>2</sub>

### Technical Tips

For typical operating parameters refer to Product Information Report – Typical Operating Parameters.

