

<p><b><u>Properties (MIG Wire):</u></b>  <b>Gas Flow Rate:</b> 20-60 CFH  <b>As Welded Hardness:</b> 25-35 HRC  <b>Shielding Gases:</b> 75% Argon, 25% CO2  90% Argon 10% CO2  92% Argon, 8% CO2</p>	<p><b><u>Properties (TIG Rod):</u></b>  <b>Gas Flow Rate:</b> 20-40 CFH  <b>Shielding Gases:</b> 100% Argon  <b>As Welded Hardness:</b> 25-35 HRC</p>	<p><b><u>Properties (Electrode):</u></b>  As Welded Hardness:  35-45 HRC</p>
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### Description:

P-20 is used to repair many types of P-20 tools and is used for high strength joining of low alloy and Chrome Moly steels. It is a medium carbon low alloy steel, with the deposits being that of an AISI P-20 mold steel. The hardness of P-20 is dependent on cooling rate, preheat temperatures and length of time welding. The P-20 electrodes are designed for superior weldability, with good wet out, stable arc, no spatter, and easy slag removal. The P-20 MIG are designed to have smooth wire feeding with a stable spatter free arc. The P-20 TIG rods are designed to obtain microscopic clean weld deposits.

### Chemical Composition (Wt%)

C	Mn	Cr	Si	Mo
0.35	0.30	1.70	0.50	0.40

Note: Single values are maximum unless otherwise noted.

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.