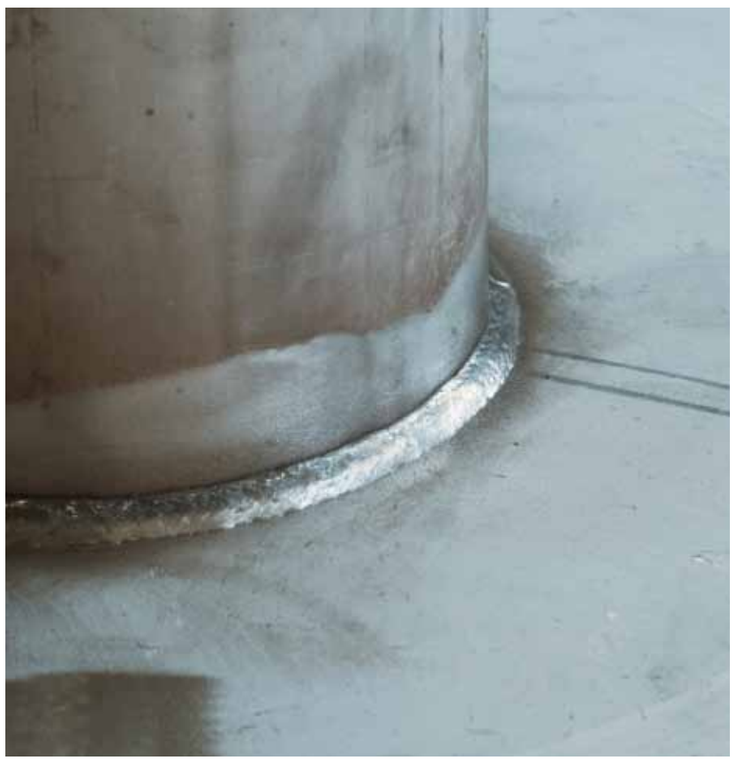
THE LINDE GROUP

Shielding gas.

Gases for all types of stainless steel.



MAG welding.

CRONIGON 2

- General purpose mixture
- Smooth weld surface – improves corrosion resistance
- Low spatter levels – reduces clean up time

CRONIGON 2He38

- Good fusion and penetration – low reinforcement levels
- Low surface oxidation and improved corrosion resistance
- High welding speeds – reduces distortion

CRONIGON 2He55

- Fast welding speed – higher productivity
- Good penetration and fusion – lowers defect levels
- Good low temperature toughness and corrosion resistance

	Welding speed	Spatter control	Reduced surface oxide	Porosity control	Fusion	Penetration	Ease of use	Thickness range (mm)
CRONIGON 2	●	●●	●●	●●	●●	●	●●	1 to 6
CRONIGON 2He38	●●	●●●	●●●	●●●	●●●	●●●	●●●	3 to 15+
CRONIGON 2He55	●●●	●●●	●●●	●●●	●●●	●●●	●●	1 to 12

Flux and metal cored arc welding.

Carbon dioxide

- General purpose gas suitable for most wires
- Good fusion and penetration even in position
- Less stable arc can produce spatter – increases clean up time

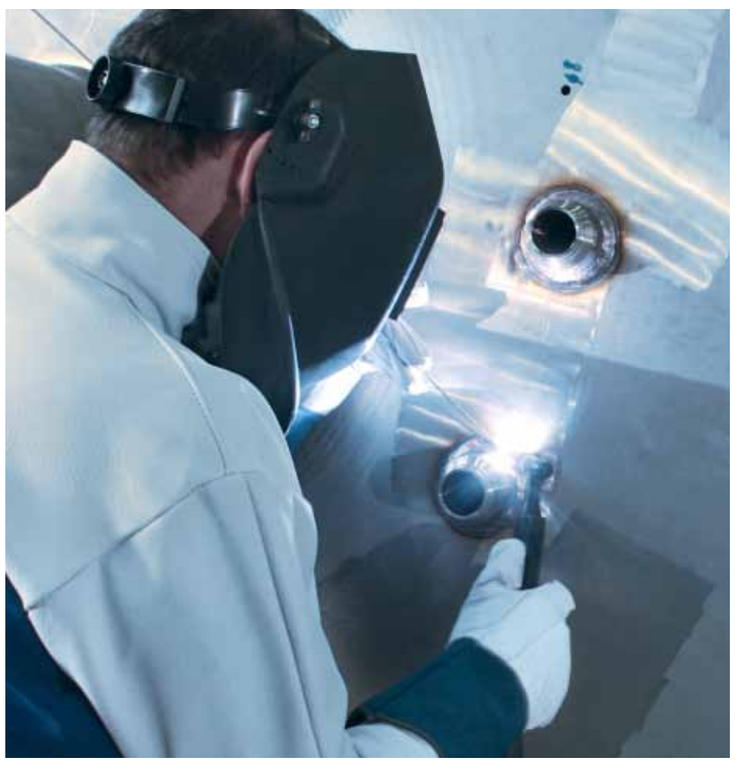
CORGON 25

- Suitable for wires designed for mixed gases
- Less spatter – reduces clean up
- Lower particulate fume – improves workplace environment

CRONIGON 2

- Used with some metal cored wires
- Lower surface oxide – reduces clean up time
- Less spatter – reduces clean up

	Welding speed	Spatter control	Porosity control	Fusion	Penetration	Ease of use	Thickness range (mm)
Carbon dioxide	●●	●	●●	●●●	●●●	●●	0 to > 25
CORGON 25	●●	●●	●●●	●●	●●●	●●●	0 to > 25
CRONIGON 2	●●	●●	●●	●●	●●	●●●	0 to > 25



TIG and plasma welding.

Argon 4.6

- Most commonly used gas
- Suitable for welding and purging all stainless steels
- Can have fusion problems on thicker materials

VARIGON H2

- Used on austenitic grades
- Fluid weld pool – increases welding speed
- Very clean weld surface – reduces need for cleaning

VARIGON H5

- Used for automatic welding of austenitic grades
- Good penetration and fusion – reduces defect risk
- Increases welding speed – improves productivity

VARIGON H10

- Primarily use plasma welding of austenitic grades
- Fluid weld pool – aids key hole formation
- High welding speed – helps control distortion

VARIGON N2.5

- Used for duplex grades
- Improved corrosion resistance
- Porosity issues with high N_2 wires

VARIGON He30

- Suitable for all stainless steels
- Good fusion reduces defect levels
- Higher welding speeds – improved productivity

	Types of stainless steel suitable	Welding speed	Porosity control	Fusion	Penetration	Ease of use	Thickness range (mm)
Argon 4.6	all	●	●	●●	●	●●	0 to 3
VARIGON H2	austenitic	●●	●●●	●●●	●●	●●●	0 to 10
VARIGON H5	austenitic	●●●	●●●	●●●	●●●	●●	1 to 10+
VARIGON H10	austenitic	●●●	●●●	●●●	●●●	●	6 to 10+
VARIGON N2.5	duplex	●●	●●	●●	●●	●●	0 to 10
VARIGON He30	all	●●●	●●●	●●●	●●●	●●	0 to 10

The greater the number of dots, the better the gas performs.

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