

USE STANDARD **STAINLESS STEEL TYPES AISI 304/304L AND 316/316L** OR **TITANIUM** FOR MECHANIZED, ORBITAL OR MANUAL TIG/GTAW WELDING.

1

- No edge preparation needed. Just align the pieces with straight edges.
- Shake the bottle well before use.
- Apply a very thin layer of coating on a cold work piece (Image A).
- Apply the flux along the entire length about 10-20 mm wide.
- You can weld immediately or later.

2

- Try welding a few times to adjust the correct electrical current and welding speed.
 - It is much easier to determine the correct current and speed when welding without filler material at the start.
 - Start with these approximate current values:
 - + 90A at 3 mm*
 - + 110A at 4mm*
 - + 130A at 5mm*
 - + 150A at 6mm*
- *material thickness*

Welding has to be slow enough to achieve full penetration of the thick material. Although the welding speed of thicker materials with BOOSTER is lower, the end result is achieved much quicker, since there is no edge preparation needed and only one pass is enough instead of multiple passes (Image B, C).

3

Full penetration is indicated by a drop on the surface of the melted pool. If you are a beginner, a colleague can help you by observing the weld from below. Colleague can indicate the moment of full penetration, while you are paying attention to the melting pool.

If you would like to compare welding of the same material with or without BOOSTER directly, apply it to the first half of the weld and then continue to weld the entire length with same parameters.

