

# Inoxline N2C3 He ZERO.

The Inoxline N2C3 He ZERO mixture is designed for the welding of austenitic and austenitic-ferritic (duplex) stainless steels. This precise blend can replace traditional Helium containing mixtures while maintaining high levels of weldability and weld quality.

## Description

Inoxline N2C3 He ZERO is designed for welding 300 series and duplex stainless steels. This shielding gas allows the operator to maintain a high arc travel speed, while maintaining a very high fluidity of the weld pool. This results in excellent wetting and a high-quality, clean and bright weld finish.

This mixture allows welding in short-circuit, axial spray and pulsed mode. It is advantageous in short-circuit mode in vertical downward position in thin sheets. Furthermore, metal deformation is reduced to a strict minimum as the arc voltage required and resulting heat input, is lower than with traditional mixtures of Argon, CO<sub>2</sub> and Helium.

## Processes

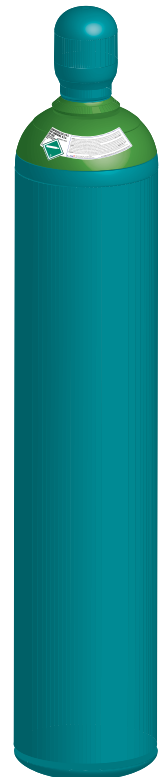
- GMAW/MIG

## Benefits and Features

- Ideal for light sheet welding on 300 series stainless steel
- Higher feed speed than with traditional mixes
- Produces flatter, smoother, broader and shinier weld beads
- Reduces arc welding time, porosity, oxidation, heat input and assembly distortion

## Packaging

- CGA: 580 / 680 (L size)
- Large cylinders
- MCP Bulk Packs



## Welding Parameters

Wire diameter	Wire feed speed (in/min)	Amperage (A)	Voltage (V)*
0.035" (1.0 mm)	275-375	115-145 (short arc)	18-20
0.035" (1.0 mm)	250-350	90-120 (pulsed spray arc)	20-22
0.045" (1.02 mm)	200-275	150-195 (short arc)	19-21
0.045" (1.02 mm)	200-275	150-195 (pulsed spray arc)	21-23

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