

**FC 8226G**

DC+

STEEL**DESCRIPTION**

Gas shielded flux-cored wire with slag from a unique concept : **the shell is WELDED, DRAWN OUT AND COPPER CLADDED**. This micro-alloy rutile is specially designed for welding mild steels and low alloy steels.

CHARACTERISTICS

- **Excellent all-position weldability**
- Easy flux removal
- Exceptional moisture resistance
- Very low spatter
- Superior mechanical properties, even at low temperatures
- Better current carrying capability
- Improved arc stability and regular feed

TYPICAL APPLICATIONS

Shipbuilding, steel and vessel construction, mechanical engineering, pipe work, farm machinery, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** or **Soudotec G12** electrode. For high thickness parts, preheating is recommended. Let cool slowly. Remove slag between each pass.

MECHANICAL PROPERTIES

Tensile strength: 79 800 psi (550 MPa) to 94 300 psi (650 MPa)
 Yield strength: > 68 200 psi (> 470 MPa)
 Elongation: > 22 %
 Impact (Charpy V): > 60 J at -40°C

WELDING PARAMETERS

Gas: 100 % CO₂ or Ar/CO₂ mixture

Diamètre	.045" (1.2 mm)	1/16" (1.6 mm)
Amperage	160 - 350	200 - 470
Voltage	20 - 35	21 - 36
Stick-out	1/2" à 1"	1/2" à 1"
Débit gaz	35 - 45	35 - 45

Packaging: 16 kg spool

Rév.: 21_08

Specialized welding alloys and technology. For technical assistance or for ordering: