


**FC 8271G** DC+

**Cr - Mo STEEL**

### DESCRIPTION

Low alloy chrome-molybdenum, gas shielded flux-cored wire with slag, for welding low alloy steels and carbon steels. Specifically recommended for welding steel containing 2.25% Cr - 1% Mo and similar grades.

### CHARACTERISTICS

- Excellent all-position weldability
- Service temperature up to 550°C (1022°F)
- Good elongation
- Excellent machinability
- Stable arc and low spatter
- Easy to remove slag

### TYPICAL APPLICATIONS

Alloy steel with chrome-molybdenum of the 4000 series (AISI), construction steel, tubes, motorcycle parts, molds and dies, etc.

### PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec 212 SP** or **Soudotec G12** electrode. Remove slag between each pass. Let cool slowly. For medium carbon steels and on thick sections, preheating is recommended.

### MECHANICAL PROPERTIES

Tensile strength:	95 000 psi (655 MPa)
Yield strength:	65 300 psi (450 MPa)
Elongation:	22 - 26 %

### WELDING PARAMETERS

Gas:	Ar/CO <sub>2</sub> mixture or 100% CO <sub>2</sub>	
Diameter:	.045" (1.2 mm)	1/16" (1.6 mm)
Amperage:	150 - 330 A	150 - 410 A
Voltage:	21 - 29 V	21 - 25 V
Stick-out:	1/2" - 5/8"	1/2" - 3/4"
Gas flow rate (c.f.h.):	40 - 50	40 - 50
Packaging:	11.4 kg spool	

Electrodes also available: **Soudotec 271**

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