


**FC 8205G DC+**
**ALLOY STEEL**
**DESCRIPTION**

Flux Cored wire with gas (FCAW) for joining and repairing high carbon steels, armor plate, **difficult-to-weld steels** and manganese steels.

**CHARACTERISTICS**

- Good crack-resistant deposit
- Excellent mechanical properties
- Work hardening deposit
- Excellent corrosion, oxidation and thermic shock resistance up to 600 °C (1112°F)

**TYPICAL APPLICATIONS**

Excellent for dissimilar assemblies, armor plate, austenitic manganese steel, propellers, pumps, valves, frames, shafts, impellers, housings, etc. Also excellent as a cushion before hardfacing.

**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 some high alloy steels, preheating is recommended. Remove slag between passes.

**MECHANICAL PROPERTIES**

Tensile strength:	95 000 psi (660 MPa)	
Yield strength:	69 000 psi (475 MPa)	
Elongation:	38 %	
Hardness:	250 BH	Work-hardened: 500 BH

**WELDING PARAMETERS**

Gas: 100 % CO<sub>2</sub> ou 75 % Ar + 25 % CO<sub>2</sub>

<b>Diameter :</b>	<b>1.2 mm .045"</b>	<b>1.6 mm 1/16"</b>
<b>Amperage</b>	100 – 250 A	125 – 275 A
<b>Voltage</b>	23 – 30 V	24 – 32 V
<b>Stick-out</b>	1/2" à 1"	1/2" à 1"
<b>Gas (pch)</b>	40 - 50	40 - 50

Packaging: 15 kg spool

Rev. : 21\_08

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