


FC 8206G DC+
ALLOY STEEL
DESCRIPTION

Gas shielded high alloy flux-cored wire **with slag** for joining and repairing high carbon steels, **difficult-to-weld steels** and manganese steels (11-14% Mn).

CHARACTERISTICS

- **High crack-resistant deposit**
- All-position welding except vertical down
- Excellent mechanical properties
- Low spatter and easy slag removal
- Work hardening deposit
- Excellent corrosion, oxidation and thermic shock resistance
- High deposit rate

TYPICAL APPLICATIONS

Dissimilar assemblies, propellers, pumps, valves, frames, shafts, impellers, housings, etc. 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.

MECHANICAL PROPERTIES

Tensile strength:	100 000 psi (690 MPa)	
Yield strength:	80 000 psi (550 MPa)	
Elongation:	35 %	
Hardness:	250 BH	Work-hardened: 525 BH

WELDING PARAMETERS

Gas:	100 % CO ₂ or 75 % Ar + 25 % CO ₂	
Diameter:	.045" (1.2 mm)	1/16" (1.6 mm)
Amperage:	100 - 250 A	125 - 275 A
Voltage:	23 - 30 V	24 - 32 V
Stick-out:	1/2" - 1"	1/2" - 1"
Gas flow rate (c.f.h.):	40 - 50	40 - 50
Packaging:	4.5 kg and 15 kg spool	

Electrodes also available: **Soudotec 206**

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