


FC 8220G DC+
ALLOY STEEL

DESCRIPTION

High strength basic type **gas shielded** alloy flux-cored wire **with slag**, for welding medium carbon steels, low alloy steels, fine-grained steels, high yield strength and crack-sensitive steels.

CHARACTERISTICS

- **Excellent all-position weldability**
- Crack-resistant deposit
- Excellent mechanical properties
- Very high quality and flame cuttable deposit
- Stable arc and low spatter
- Very good X-ray quality

TYPICAL APPLICATIONS

Steel types Jalloxy, 4130, 4140, 4340, T1, HY-90, SPS 245, CHT 360, SS-100, 400, 500, Scandia 100 - 200 - 300 - 400 Brinell, Corten and Hardox steel, etc. Pipes, plates, heavy equipment parts, construction and mining equipment such as blades, buckets, boom cranes, crane and shovels. Can be used for truck and bus frames.

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:	112 000 psi (772 MPa)
Yield strength:	90 000 psi (618 MPa)
Elongation:	23 %
Impact strength (Charpy V):	75 J at -32°C

WELDING PARAMETERS

Gas:	75 % Ar + 25 % CO ₂ or 100% CO ₂	
Diameter:	.045" (1.2 mm)	1/16" (1.6 mm)
Amperage:	150 - 325 A	150 - 400 A
Voltage:	22 - 30 V	22 - 26 V
Stick-out:	1/2" - 5/8"	1/2" - 3/4"
Gas flow rate (c.f.h):	40 - 50	40 - 50
Packaging:	4.5 kg and 11.4 kg spool	

Electrodes also available: **Soudotec 220**

Rev.: 21_08

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