


FC 8265G DC+
ALLOY STEEL**DESCRIPTION**

High alloy **gas shielded** flux-cored wire **with slag**, for joining low and high alloy steels and all types of **unknown steels** together, or as **dissimilar assemblies**. Excellent as a cushion before hardfacing on high alloy steels.

CHARACTERISTICS

- **Exceptional mechanical properties**
- All-position welding
- High compressive stress resistance and crack-resistant deposit
- Corrosion resistance up to 300°C / 572°F and oxidation resistance up to 1000°C / 1832°F
- Machinable deposit
- Low spatter and easy slag removal
- High deposit rate

TYPICAL APPLICATIONS

Parts of unknown steel grades, tools and dies, construction equipment, shafts and gears, also for rebuilding shafts and blades.

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:	122 000 psi (841 MPa)	
Yield strength:	90 000 psi (620 MPa)	
Elongation:	30 – 35 %	
Hardness (as-welded):	22 HRC	Work-hardened: 52 HRC

WELDING PARAMETERS

Gas:	100 % CO ₂ or 75 % Ar + 25 % CO ₂		
Diameter:	.035" (0.9 mm)	.045" (1.2 mm)	1/16" (1.6 mm)
Amperage:	70 - 160 A	135 - 250 A	170 - 300 A
Voltage:	20 - 35 V	24 - 32 V	25 - 33 V
Stick-out:	½"	½"-1"	½"-1"
Gas flow rate (c.f.h):	35 - 45	40 - 50	40 - 50

Packaging: 4.5 kg and 15 kg spool

Electrodes also available: **Soudotec 265** and TIG rods: **Soudotec T265**

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