


FC 8277G DC+

ALLOY STEEL

DESCRIPTION

High alloy **gas shielded** flux-cored wire **with slag**, for welding medium and high carbon steels, **unknown stainless steels**, manganese steels and difficult-to-weld steels. Excellent as a cushion before hardfacing on crack sensitive steels.

CHARACTERISTICS

- **Excellent all-position weldability**
- Exceptional elongation
- Excellent corrosion resistance
- Crack-resistant deposit
- Work hardening deposit
- Low spatter and easy slag removal
- High deposit rate

TYPICAL APPLICATIONS

Heavy equipment, shovel buckets, railroad industries; crossings, frogs and switches, axles, dies, high strength low alloy steels. (CHT 445 - Scandia 400 - T1, 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 some high alloy steels, preheating is recommended.

MECHANICAL PROPERTIES

Tensile strength:	90 000 psi (618 MPa)
Yield strength:	70 000 psi (480 MPa)
Elongation:	41 %
Impact (Charpy V):	60J at +20°C

WELDING PARAMETERS

Gas:	100 % CO ₂ or 75 % Ar + 25 % CO ₂
Diameter:	.045" (1.2 mm) 1/16" (1.6 mm)
Amperage:	130 - 220 A 170 - 300 A
Voltage:	25 - 30 V 26 - 31 V
Stick-out:	½" - 1" ½" - 1"
Gas flow rate (c.f.h):	40 - 50 40 - 50

Packaging: 4.5 kg and 15 kg spool

Electrodes also available: **Soudotec 277** and TIG rods: **Soudotec T277**

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