



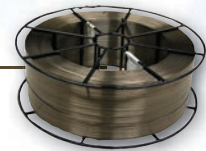
## Thermex™ FC-G Multi-Purpose Super Alloy Flux Core Wire

Thermex FC-G is a high strength flux core wire with a high nickel content that can be used for welding in all positions. It offers outstanding weldability and can be used to join a variety of similar and dissimilar alloys and nickel based alloys such as Inconel® and Incoloy®. In addition, it offers excellent corrosion and heat resistance.

Features and benefits:

- Versatile — Well suited for welding Inconel 625, 706, 718 and X-750; Incoloy 800 and 825; Monel® alloy K-500, Ferralium® 255, Hastelloy® B, C or G, and Carpenter 20 Cb-3® and combinations of these alloys\*
- Corrosion resistant — Highly resistant to chloride pitting and stress corrosion cracking
- Excellent for dissimilar nickel alloys and nickel to ferrous alloys
- Excellent for cryogenic applications
- Heat resistant to 1800°F/982°C
- Resists cracking when heated and cooled repeatedly

*\* Registered alloy tradenames remain property of their respective holders, and are used only to directly describe the product mentioned. Their use in no way indicates any relationship between Partsmaster and the holders of said trademarks.*

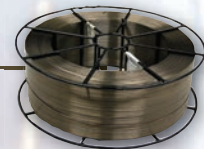


### SPECIFICATIONS

Tensile strength .....	110,000 psi (758 MPa)
Yield strength .....	72,000 psi (496 MPa)
Hardness .....	21Rc
Impact Strength .....	48 ft -lbs @ -320°F / -196°C
Elongation .....	38%

### WELDING PARAMETERS:

Current .....	DCEP (DC+)
Gas .....	75% Ar / 25% CO2 or 100% CO2



### PROCEDURES

Use 75% Ar / 25% CO2 or 100% CO2 as a shielding gas. Prepare surface by removing all defective material with Trust-X® grinding disks or Cryo-Burrs™. For most applications, the outstanding crack resistance of Thermex eliminates the need for preheating or post heating. Use DCEP and maintain a short arc.

### APPLICATIONS

- Chemical piping
- Scrubbers
- Cryogenic applications
- Petro-chemical equipment
- Heat treating racks and equipment
- Pumps and valves
- Joining dissimilar alloys

  
<https://dod.emall.dla.mil>  
 SP47W1-17-D-0009  
 Available in select sizes only



Code #	Spool	Diameter	Amperage	Volts	Electrode Stick-Out
684-8-0045	33#	.045"	150-200	25-26	.1/2"