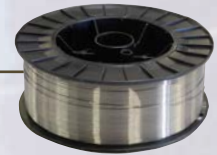


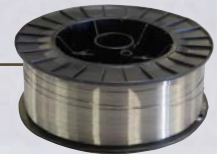
## Tuff-Plus™ FC All-Position High-Strength Low-Alloy Steel Flux Cored Wire

- High-strength low-alloy formulation
- High deposition rate
- Low smoke and spatter
- Exceptional out-of-position qualities
- Low-hydrogen flux
- Easy slag removal and clean up



### SPECIFICATIONS

Tensile strength.....	115,000 psi/793 MPa
Yield strength.....	101,000 psi/715 MPa
Hardness.....	21Rc
Elongation.....	24%
Machinability.....	Excellent
Current.....	DCEP (DC+)
Gas.....	100% CO <sub>2</sub> or 75% Ar/ 25%CO <sub>2</sub>



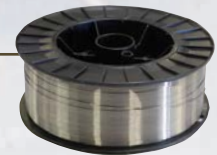
### PROCEDURES

Best results are achieved by first removing fatigued metal, dirt, grease, paint and any other contaminants. Preheat heavy sections and alloy steels according to composition. Use 100% CO<sub>2</sub> or Argon/CO<sub>2</sub> for shielding gas. A 75% Argon/25% CO<sub>2</sub> gas mixture improves arc characteristics in out-of-position work and provides increased wetting action, decreased penetration, and easier arc control. Both stringer and weave techniques can be used. Employ at 2-15° leading gun angle for flat and horizontal positions. A lagging angle is preferred for vertical up.

### APPLICATIONS

- Heavy construction mining equipment
- Alloy steels
- Padding and build-up prior to hardfacing
- T-1 steel
- 4140 alloy steel
- Earthmoving equipment
- Pipe welding
- Truck frames
- AR plate
- HSLA steels
- HY100
- 4340 alloy steel
- Rail car repair
- Axles

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



Code #	Spool	Diameter	Amperage	Volts	Electrode Stick-out
602-8-0045	33#	.045"	150-250	22-26	3/4"
602-4-0062	10#	1/16"	180-300	21-27	3/4"
602-8-0062	33#	1/16"	180-300	21-27	3/4"

Also available in:

