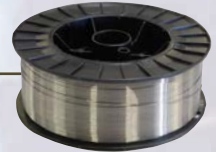
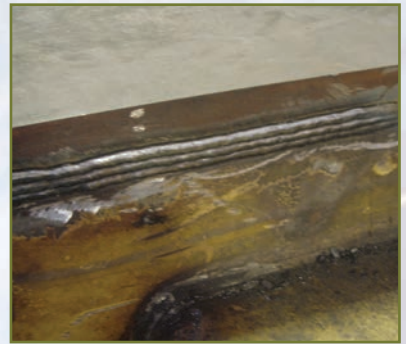


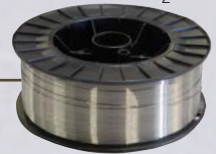
## Dura-Weld™ FC All-Position High-Strength Steel Flux Cored Wire

- Gas shielded
- Outstanding out-of-position welds
- Low-hydrogen flux for critical applications
- High deposition rates
- Easy slag removal
- Reduced smoke
- Very low spatter



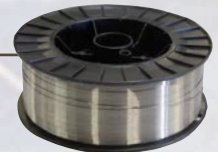
### SPECIFICATIONS

Tensile strength.....	90,000 psi/621 MPa
Yield strength.....	78,900 psi/594 MPa
Hardness.....	91 Rb
Elongation.....	26%
Impact strength (Charpy).....	0°F/-18°C, 32 ft-lbs
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

- |                     |                  |                          |
|---------------------|------------------|--------------------------|
| • Galvanized steels | • Conveyor parts | • AR plate               |
| • Thin sheet metal  | • Angle iron     | • Construction equipment |
| • Farm equipment    | • Trailers       | • Steel axles            |
| • Guard rails       | • Pipe welding   | • Concrete forms         |
| • Hitches           | • Tubing         | • Brackets               |
| • Plate steel       | • Channel iron   | • Shaft buildup          |
| • Haultruck beds    |                  |                          |



Code #	Spool	Diameter	Amperage Position	Volts Position	Amps Flat	Volts Flat	Electrode Stick-Out
660-4-0035	10#	.035"	90-180	16-23	130-280	20-30	1/2" – 1"
660-4-0045	10#	.045"	120-210	21-26	140-290	22-30	5/8" – 1-1/4"
660-4-0062	10#	1/16"	150-250	21-27	180-400	24-34	3/4" – 1-1/4"
660-8-0035	33#	.035"	90-180	16-23	130-280	20-30	1/2" – 1"
660-8-0045	33#	.045"	120-210	21-26	140-290	22-30	5/8" – 1-1/4"
660-8-0062	33#	1/16"	150-250	21-27	180-400	24-34	3/4" – 1-1/4"
660-9-0062	60#	1/16"	150-250	21-27	180-400	24-32	3/4" – 1-1/4"

Also available in:

