



a quality welding alloy

ARCtec® FCO 225 N

Conforms to: AWS A5.29 Class E71T8-Ni I

GENERAL CHARACTERISTICS:

ARCtec® FCO 225 N is a self-shielding flux cored welding wire that produces weld deposits with outstanding low temperature impact toughness. This wire does not require the use of a shielding gas.

APPLICATIONS:

ARCtec® FCO 225 N is suitable for all position welding on steel structures and equipment components where excellent impact toughness is required. This wire meets the requirements of AWS specifications A 5.29, Classification E-71T8-Ni I and should find excellent acceptance in general steel fabrication and repair of heavy equipment components.

MECHANICAL PROPERTIES:

| | | | |
|--|--------------------------------------|----------------------|--|
| Tensile Strength 76,100psi (525Mpa) | Yield Strength 61,500psi (424Mpa) | Elongation 30%-2" | Impact Strength 119 ft.lb (161J) @ -20°F (-29°C) 82 ft.lb (111J) @ -60°F (-51°C) |
|--|--------------------------------------|----------------------|--|

CHEMICAL COMPOSITION: (TYPICAL UNDILUTED)

| | | | | | | |
|---|----|---|---|----|----|----|
| C | Mn | S | P | Si | Ni | Al |
|---|----|---|---|----|----|----|

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

POLARITY: DC Straight

| Operating Range | | | | |
|-----------------|-------------|---------------------|------|-------|
| Diameter | Stickout | Wire Feed Speed | Amps | Volts |
| 1/16" | 5/8" (15mm) | 100"/min (43mm/sec) | 135 | 19-20 |
| 1/16" | 5/8" (15mm) | 130"/min (55mm/sec) | 200 | 20-21 |
| 1/16" | 5/8" (15mm) | 160"/min (68mm/sec) | 230 | 21-22 |

STANDARD SIZE AND PACKAGING:

| Size | Packaging | |
|-------------|------------------|------------------|
| 1/16" 1.6mm | 12" spools 15 Kg | 12" coil 22.7 kg |

| | | | |
|-----------------------------------|---------------------------------|----------------------------------|---------------------------------|
| CALGARY FAX:(403)-250-7682 | EDMONTON: (780)-484-4896 | VANCOUVER: (604)-596-2940 | WINNIPEG: (204)-663-7955 |
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Subject to change without notice

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