



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)
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CHEMICAL COMPOSITION: (TYPICAL UNDILUTED)

C	Mn	S	P	Si	Ni	Al
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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

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Subject to change without notice

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