



a quality welding alloy

ARCtec® FCO 222

Conforms to: AWS A5.20 Class E-71T-11

Certified by CWB to CSA W48-01 E491T-11-H16

GENERAL CHARACTERISTICS:

ARCtec® FCO 222 is an all position, self-shielding flux cored welding wire for automatic and semi-automatic welding processes. Single and multiple pass applications on thin gauge and heavier sections of low and medium carbon steel. Ideal for welding outdoors where drafts may cause gas shielding difficulties.

APPLICATIONS:

ARCtec® FCO 222 is excellent for use on single and multiple pass lap, fillet and butt welds on mild steel in all welding positions. It offers smooth arc action, easy slag removal and low spatter. Also meets all requirements for Classification E-71T-11 in AWS specifications A 5.20. Bead appearance and weld edges are smooth and no shield gas is required. This product should find excellent acceptance in general mild steel fabrication and repair of machine basics and some heavy equipment components.

MECHANICAL PROPERTIES:

Tensile Strength	Yield Strength	Elongation
88500-91200psi	62500-65000psi	22-24%-2"
610-629Mpa	431-448Mpa	

CHEMICAL COMPOSITION: (UNDILUTED)

Al	Mn	Si	C	P	S	Fe
1.65	.70	.40	.25	.007	.004	Bal

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

POLARITY: DC Straight

Operating Range				
Diameter	Stickout	Wire Feed Speed	Amps	Volts
.045"	1/2"(12mm)	124"/min (52mm/sec)	150-160	17-18
1/16"	3/4"(19mm)	96"/min (41mm/sec)	200	18

STANDARD SIZE AND PACKAGING

Size	Packaging
.045" 1.2mm	12" spools 15 Kg
1/16" 1.6mm	12" spools 15 Kg

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Subject to change without notice

OHO020703/237-4