

770

Recommended Welding Parameters

Tensile Strength: 105,00—115,000 PSI

Elongation: 30-36%

MN-FCG - Gas shielded flux cored wire (CO₂ or Ar-25% CO₂)

Diameter	Polarity	Current (amps)	Voltage	ESO
.045"	DCRP	150-220	24-29	1/2"-1"
1/16"	DCRP	180-275	26-30	3/4"-1 1/4"
5/64"	DCRP	240-400	26-32	3/4"-1 1/4"
3/32"	DCRP	280-400	26-33	1"-1 1/4"
7/64"	DCRP	300-400	27-32	1 1/4"-1 3/4"
1/8"	DCRP	400-450	29-33	1 1/4"-1 3/4"

Note: Listed parameters are for CO₂ shielding. Lower by one volt for Ar-25% CO₂.

MN-FCO - Open arc, flux cored wire

1/16"	DCRP	200-250	26-30	3/4"-1 1/4"
7/64"	DCRP	300-400	26-31	1 1/4"-1 3/4"