

Eagle-Arc

Cored Welding Wire

Stainless & Mild Steel



Eagle-Arc Cored Wires

Eagle-Arc 71

AWS A5.20, E71T-1C/1M

Eagle-Arc 71 Flux Core is an *all-position*, single or multi-pass wire for welding on mild and carbon steel. Features excellent feedability and operator appeal including; stable arc, low fume emissions and low spatter levels. Weld deposit exhibits good tie-in and geometry with self-peeling slag. This wire is designed for use with 100% CO₂ or 75-80% Argon, balance CO₂ mixed gases. Yields good penetration on light, medium or heavy gauge plate. 71 is a great choice for bridge structures, ship building, earth moving equipment and all general fabrication requirements.

Typical Chemistry

C - 0.03
Mn - 1.45
Si - 0.30
P - 0.015
S - 0.010

Typical Mechanical Properties

Tensile Strength - 86,000 psi
Yield Strength - 81,000 psi
% elongation - 26
CVN 55 ft-lbs @ 0°F

Recommended Parameters

Shielding gas Ar/CO₂ (75-80% Ar)
or 100% CO₂

Amps	Flat	Horizontal	vertical
.045	120-320	120-250	120-260
1/16	150-400	200-400	160-280

Electrical stick-out 1/2 - 3/4" DC+

Actual Chemical Certification available on Request

Eagle-Arc 70C

AWS A5.18, E70C-6M

Eagle-Arc 70C Metal Core is a gas shielded wire for single or multi-pass welding in the flat or horizontal position on mild steel. This alloy is virtually free of spatter and slag, drastically reducing clean-up time. The smooth, stable arc leaves an excellent bead appearance with superior tie-in. This alloy is formulated for high deposition and weld efficiency and will operate on shielding gas with 75-80% argon/balance CO₂. Common uses include; Construction, erection and fabrication of heavy equipment, construction machinery and general fabrication of mild steel.

Typical Chemistry

C - 0.04
Mn - 1.55
Si - 0.54
P - 0.014
S - 0.015

Typical Mechanical Properties

Tensile Strength - 89,000 psi
Yield Strength - 77,000 psi
% elongation - 27
CVN 29 ft-lbs @ 0°F to
35 ft-lbs @ -20°F

Recommended Parameters

Shielding gas Ar/CO₂ (75-80% Ar)

Amps	Flat	Horizontal
.045	160-350	180-360
1/16	220-450	280-450

Electrical stick-out 1/2 - 3/4" DC+

Actual Chemical Certification available on request

Packaging

Eagle-Arc Cored Wires come in the following spool sizes:

.045 x 10, 33 & 44 lb spool

.052 x 33 & 44 lb spool

1/16 x 33 & 44 lb spool

33 and 44 lb spools are hermetically sealed in vacuum packaging.

For spools, coils and drums not shown
please contact your Washington Alloy representative for quotation.



Washington Alloy maintains an
ISO 9001
certified quality management system

WASHINGTON ALLOY DISTRIBUTION CENTERS

East Coast:

7010-G Reames Rd.
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