



Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925

Stainless Steel Flux Cored Welding Parameters

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
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TYPICAL FCAW WELDING PROCEDURES; DCEP

(Based on 100% CO₂ for 75% Argon & 25% CO₂ lower volts by 2 volts,

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stick-out	CO ₂ (cfh)
0.035	275-290	105-118	26-28	3/8-1/2"	35-45
0.035	325-340	115-135	26-28	3/8-1/2"	35-45
0.035	380-420	125-145	27-29	3/8-1/2"	35-45
0.045	260-280	155-175	26-28	1/2-3/4"	40-50
0.045	310-335	175-190	26-29	1/2-3/4"	40-50
0.045	365-400	185-210	27-31	1/2-3/4"	40-50
1/16"	215-245	200-255	29-31	1/2-1"	40-50
1/16"	245-285	240-275	30-33	1/2-1"	40-50
1/16"	285-310	280-305	30-33	1/2-1"	40-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.



4-2009 DC

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