

Brutus[®] Flux Core

Flux Core Arc Welding (FCAW -Wire)

For welding all categories of steels and dissimilar steels- alloy steels, stainless, manganese, nickel alloy and cast steels.

Features

- 125,000 psi Tensile Strength
- 35% Elongation
- Ideal For Dissimilar Steels
- Excellent Corrosion Resistance
- Wear and Shock Resistant
- Machinable
- Excellent For Out-Of-Position

Characteristics

Brutus Flux Core is for wire feed welding of steels where the type of steel is unknown or for dissimilar steels. Welds are super strong and ductile. Can also be used as cladding to provide superior corrosion resistance. Good for joining stainless steel to carbon steels, as well as stainless to stainless.

Technical

Inches	.045
(mm)	(1.2)
Volts	25 – 30
Amps	130 – 220
Stick Out	3/8" – 3/4"

Use Reverse Polarity (DCEP)

Shielding Gas Options

Gas Required

- 100% CO₂
- 75% Argon – 25% CO₂

Application

- Shielding gas can be CO₂ or 75% Argon and 25% CO₂.
- Spray transfer with easy to remove slag.
- "Buttering technique" will aid in joining dissimilar steels.
- Avoid extreme heat applications.
- We recommend **Gemini Anti-Spatter spray** for lasting protection of your contact tip and MIG nozzle (see chemical aids in Abrasives & Metal Working products section).

Spool Size

- 33# Available in .045