

# Brutus® TIG

## Gas Tungsten Arc Welding (GTAW)

For all steels: spring, mild, free machining, tool steel, stainless, manganese, cast steels.

### Features

- High Strength 130,000 psi
- Ideal For Dissimilar Steels
- Crack Resistant
- Shock Resistant
- Machinable Deposit
- Avoids Porosity

### Characteristics

**Brutus TIG** ideal for welding high carbon, alloy steels, and free machining “tramp steels”. This alloy will join broken tool steels and produce strong welds with minimum dilution of the base metal. **Brutus TIG** is suitable for building up shafts and for 330, 347, 348 and 400 series stainless.

### Technical

Inches	.035	1/16	3/32	1/8
(mm)	(0.9)	(1.6)	(2.4)	(3.2)

(DCEN)



### Application

- Clean the base metal completely.
- Make sure the first pass fuses completely.
- Brush oxide film from each deposit between multi-pass welds, use stainless brush.
- For high alloys and heavy sections, preheat to 400°F (204°C).
- Use DC straight polarity with Argon and/or Helium.

### Identification

- Marked by **Green Tip**