

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**