

**Perfect
PASS**

Welding Products
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4044 FCG

DATA SHEET

DESCRIPTION:

4044 FCG is a high strength welding wire designed for "all position: welding of carbon and high strength, low alloy steels such as Mayari, Jallo, T-1, HY-90, SSS-100.

In addition to offering excellent physical properties, weld deposits of 4044 FCG are highly crack resistant and can be used on weld joints that are under high restraint. For some applications the preheat can even be reduced or eliminated.

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|------------------|-------------|
| Tensile strength | 106,000 psi |
| Yield strength | 89,000 psi |
| Elongation | 23% |

The Superior Benefits of 4044 FCG:

- Deposits are "X-Ray Quality"
- All position weldability
- Use the single or multiple pass welding
- Deposits can be flame-cut
- Welds are exceptionally smooth and spatter-free

APPLICATIONS:

4044 FCG should be used for fabricating structural shapes such as "I" and "H" beams, channels, plates and pipes. Ideal for construction and mining equipment such as dozer blades, buckets and bucket teeth, crane and shovel booms, coal hoppers, etc. Also for truck and bus frames.

WELDING PROCEDURE:

- Use DC Reverse Polarity - 3/8" to 1/2" stick-out
- Welding Parameters:

| | | | |
|-------------|---|----------------|-------------------|
| Flat | - | 23 to 30 volts | & 150 to 290 amps |
| Vertical Up | - | 23 to 26 " | 150 to 210 " |
| Overhead | - | 23 to 26 " | 150 to 250 " |
- Gas coverage - 75 % Argon & 25% CO₂ at 30 - 35 CFH
- Preheating - High Carbon and Low Alloy should be preheated from 400° - 500° F (204° - 260° C)
- Spatter free welds can be produced by pulling the gun and wire, rather than pushing. Multipass welds, using stringer or weave beads will produce "X-Ray" quality deposits. Bead contour will be slightly convex.

Sizes Available: .045 on 25 lb spool

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