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# 4044 FCG DATA SHEET

## GENERAL CHARACTERISTICS:

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, as well as AR 400/500 plate, and other high- impact steels. 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.

## 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, truck, and bus frames, etc.

## WELDING PROCEDURE:

- Use DC Reverse Polarity – 3/8" to 1/2" stick-out
- Gas Coverage - 75% Argon & 25% CO, 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. Multi-pass welds, using stringer or weave beads will produce "X-Ray" quality deposits. Bead contour will be slightly convex.
- Welding Parameters:

Flat -	23 to 30 VOLTS	150 to 290 AMPS
Vertical Up -	23 to 26 VOLTS	150 to 210 AMPS
Overhead -	23 to 26 VOLTS	150 to 250 AMPS

## AVAILABLE SIZES:

.045 diameter on 25lb Spool



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