

Flux Cored Wire & Submerged arc welding wire

Welding Notes (FCW and SAW Composite Wire)

1. Use DC Electrode Positive (DCEP, DC+, DC Reverse Polarity).
2. Suitable shielding gas and flow rate : see below

Shielding gas type	Shielding gas flow rate L/mm
CO ₂ or 5~20%CO ₂ + Ar	20~25
none	----

3. Recommended welding parameters (Self shield & gas shield flux cored wire)

wire diameter	1.2mm	1.6mm	2.4mm	2.8mm
polarity	DC+	DC+	DC+	DC+
welding current	150~250	175~350	200~400	230~450
welding voltage	24~30	26~32	30~35	32~38
wire extension	15~25mm	15~25mm	25~40mm	25~45mm
	gas shielded		self shielded	

Note: Consult individual product notes for details.

4. Welding parameters and related characteristics :

Description	
wire feed speed (current-Amp) ↑increase	deposition rate↑ penetration depth↑ heat input↑
welding voltage (V) ↑increase	bead width↑ surface flatness↑ blow hole↑
Wire extension ↑increase	fusion rate↑ weld spatter↑ blow hole↑

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5. Recommended welding parameters (for SAW)

Wire diameter	2. 8mm	3. 2mm
polarity	DC+	DC+
welding current (A)	280~350	320~400
welding voltage (V)	28~32	30~36
wire extension (mm)	20~35	25~40
flux	neutral type fl ux	neutral type fl ux