

Flux Cored Mild Steel MIG Wire

Description

Ten gauge is a self-shielded carbon steel wire for single pass fillet and lap welds in mild and low carbon steel. It is an excellent welding wire for home, workshop, and auto repair! Ten Gauge's innovative composition provides the following welding features:

- ◆ DC straight polarity minimizes burn through on thin sheet metal.
- ◆ Excellent for plain and galvanized steels.
- ◆ A good choice for 110 volt welding machines – no gas bottle required.
- ◆ Wide weld range of steel thickness, 18 gauge, (0.048') to 1/4" (0.125).
- ◆ All position capability – excellent on vertical down welding.
- ◆ No shielding gas means reduced welding costs and the ability to weld in windy conditions.
- ◆ Easily removed slag.

Typical Single Pass Weld Deposit Chemistry (%)

Carbon – 15 Sulfur – 0.007
Manganese – 0.55 Iron – Remainder
Silicon – 0.45

Typical Weld Metal Mechanical Properties

Transverse Tensile Test: 80,100PSI, base metal fracture.

Seecification Conformance

AWS A5.20, ASME Section 11Part C SFA 5.20 Classification
E7iT-GS



Suggested Welding Settings [DC straight polarity, (electrode negative), polarity.]

Metal Tickness	Joint Type	Wire Feed Speed	Amperage	Voltage	Stick Out
<i>Suggested Weld Settings - .030"/.8mm DIAMETER</i>					
18 GA	Fillet (lap-tee)	125	4	12-14	1/2"
16 GA	Fillet (lap-tee)	125-200	80-110	13-17	1/2"
10 GA	Fillet (lap-tee)	200-350	125-160	15-21	1/2"
10 GA	Square groove	400	180-195	21-23	5/8"
1/4"	Fillet (lap-tee)	500-600	180-195	22-24	5/8"
<i>Suggested Weld Settings - .035"/.9mm DIAMETER</i>					
16 GA	Fillet (lap-tee)	60-100	50-90	14-16	1/2"
10 GA	Fillet (lap-tee)	125-200	100-125	17-22	1/2"
10 GA	Square groove	125-200	100-125	19-22	1/2"
1/4"	Fillet (lap-tee)	400-500	220-245	22-26	1/2"
1/4"	Square groove	500-700	180-215	24-28	3/4"

Sizes and packages

0.30", 0.035" & 0.045" diameter x 2 lb. spool, 0.035" & 0.045" diameter x 10 lb. spool

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