

BRUTUS® - MIG

Gas Metal Arc Welding (GMAW)

For welding all steels—spring, mild, free machining, tool steel, stainless, and cast steel.

FEATURES

- Superior strength 130,000 psi
- Ideal for dissimilar steels
- Crack resistant
- Shock resistant
- Corrosion resistant
- Avoids porosity
- High elongation up to 35%
- Machinable deposit

CHARACTERISTICS

BRUTUS-MIG combines the ease of gas metal arc welding with the exceptional properties of the Brutus alloys. **BRUTUS-MIG** can be used to join and build up all types of steel where a strong and ductile alloy is required. It is particularly useful in maintenance work where the exact type of steel may not be known and for joining dissimilar steels. Excellent as a build-up for final passes of tool steel or for shaft build-up.

5

APPLICATION

The base metal must be cleaned completely. Make sure the root pass fuses completely. Oxide film from each deposit must be brushed off with stainless brush between multi-pass welds. For high alloys and heavy sections preheat to 400°F (204°C).

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	GAS FLOW (Ft ³ /Hr)
.035" (0.9mm)	15-24	60-160	15
.045" (1.2mm)	15-30	125-300	20

SHIELDING GAS OPTIONS:

99% Argon - 1% O₂

98% Argon - 2% O₂

90% Helium - 7.5% Argon - 2.5% CO₂ (Trimix)