

GEMINI® - B FLUX CORE

Flux Core Arc Welding
(FCAW - Gas Required)

For welding most stainless steels, including molybdenum bearing types.

FEATURES

- 85,000 psi strength
- Excellent out-of-position characteristics
- High deposition rate
- X-ray quality welds
- Superior corrosion resistance
- Contains molybdenum

CHARACTERISTICS

GEMINI-B FLUX CORE is a high alloy, molybdenum bearing, gas shielded flux core wire designed to be used on most types of stainless steel. It will provide welds with superior corrosion resistance, making it an excellent choice for chemical, food and refinery applications.

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APPLICATION

Shielding is obtained with CO₂. However, the use of 75% Argon and 25% CO₂ will provide optimum operating characteristics.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK OUT
.045" (1.2mm)	25-30	130-220	3/4" ± 1/4"

SHIELDING GAS OPTIONS:

100% CO₂

75% Argon - 25% CO₂

See wire feed charts in Tech Section - Page 99-104