

# POLARIS® - MAXIMUM SHIELD PLUS

Flux Core Arc Welding

(FCAW - Gas Required)

For welding high strength, low alloy and medium carbon steels.

Also for wear resistant steels.

## FEATURES

- 90,000 psi strength
- Excellent out-of-position
- Easy slag removal
- X-ray quality welds
- Use with CO<sub>2</sub> or 75-25
- 30% elongation
- Welds over rust and mill scale

## CHARACTERISTICS

**POLARIS MAXIMUM SHIELD PLUS** has been designed for easy all position welding of mild, medium carbon, low alloy and high strength steels. The unique highly active flux, combined with shielding gas allows **POLARIS MAXIMUM SHIELD PLUS** to run vertical up or down, overhead and horizontal with ease. Excellent results are obtained even when welding through normal rust and mill scale.

Applications include welding of construction equipment, boilers, tanks, piping, truck and bus frames and all crack sensitive steels. **POLARIS MAXIMUM SHIELD PLUS** provides an excellent pad for hard surfacing due to its extraordinary ductility.

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## APPLICATION

When used with CO<sub>2</sub> **POLARIS MAXIMUM SHIELD PLUS** has little spatter and easy slag removal. The use of 75% Argon - 25% CO<sub>2</sub> gas mix enhances the arc characteristics with smoother metal transfer, increased wetting action and lower penetration. With the 75-25 mix, voltage should be reduced by 1 to 1 1/2 Volts.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK-OUT
.035"(0.8mm)	20-26	100-250	1/4"-3/4"
.045"(1.2mm)	22-30	180-280	1/2"-3/4"
1/16"(1.6mm)	26-29	200-350	1/2"-3/4"

### SHIELDING GAS OPTIONS:

100% CO<sub>2</sub>

75% Argon - 25% CO<sub>2</sub>