

TARTAN® - B MIG

Gas Metal Arc Welding (GMAW)

For welding mild and medium alloy steels.

FEATURES

- 80,000 psi tensile strength
- High elongation
- Excellent for rust and mill scale
- Good for galvanized steel
- Superior out of position characteristics
- Excellent wetting action
- Copper flashed

CHARACTERISTICS

TARTAN-B MIG has a high silicon-manganese content providing excellent appearing welds over a wide range of welding conditions. Deposits have good wetting action.

5 The high alloying of **TARTAN-B MIG** allows a wide range of welding parameters. Good results are achieved even under adverse conditions of dirty, rusty steels. Deposits have superior mechanical properties.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

| WIRE DIAMETER | VOLTS | AMPS | GAS FLOW (Ft ³ /Hr) |
|---------------|-------|---------|--------------------------------|
| .023"(0.6mm) | 15-30 | 20-125 | 15-30 |
| .030"(0.8mm) | 15-30 | 30-200 | 20-35 |
| .035"(0.9mm) | 15-35 | 50-300 | 20-35 |
| .045"(1.2mm) | 20-35 | 115-373 | 25-35 |

SHIELDING GAS OPTIONS:

| | |
|-------------------------------|---------------------------------|
| 100% CO ₂ | 75% Argon - 25% CO ₂ |
| 98% Argon - 2% O ₂ | 80% Argon - 20% CO ₂ |
| 95% Argon - 5% O ₂ | 90% Argon - 10% CO ₂ |

See GMAW charts in Tech Section - Page 99-104