

# TARTAN® - FLUX CORE

Flux Core Arc Welding  
(FCAW)

For welding mild and medium alloy steels.

## FEATURES

- 80,000 psi strength
- Excellent elongation
- 96-98% deposition efficiency
- Excellent out-of-position characteristics
- Good quality welds
- Excellent for thin gauges

## CHARACTERISTICS

**TARTAN - FLUX CORE** is a flux core self-shielded wire superior for welding thin gauge mild and medium alloy steels. Designed for single pass applications. It is ideal on galvanized steel.

**TARTAN-FLUX CORE** is low spatter, with smooth arc characteristics and all position capabilities. Easy slag removal. Wetting action is excellent.

**TARTAN-FLUX CORE** is ideal for "suitcase" type wire feeders.

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APPROXIMATE SETTINGS: DCEN (Straight Polarity)

WIRE DIAMETER	VOLTS	AMPS	STICK OUT
.030"(0.8mm)	15-16	40-160	3/8"-1/2"
.035"(0.9mm)	15-17	70-200	1/2"
.045"(1.2mm)	13-18	80-225	1/2"

### SHIELDING GAS OPTIONS:

Not required; however, 100% CO<sub>2</sub> will enhance weld bead and lessen spatter.

**See Polarity Diagram Tech Section - Page 98**