Select Var36

Nickel Alloy / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Designed for welding various low thermal expansion alloys
- Exceptional arc stability in all positions
- Deposit chemistry meets requirements of ASTMF1684

DIAMETERS [in [mm]]

0.045 (1.2)

POSITIONS

SHIELDING GAS

75-80% Ar / Balance CO2
Flow Rate: 40 - 50 CFH

POLARITY

DCEP

TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Fe	Mn	Ni	P	S	Si
75%Ar / 25%CO2	0.02	Bal.	0.30	36.5	0.003	0.001	0.07

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	75% Ar/25% CO2	Vertical Up	260 (6.6)	180	22	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	350 (8.9)	225	23	1/2 - 5/8 (13 - 16)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*
***The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.*

PACKAGING [lbs [kgs]]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.

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