

CARBON STEEL FILLER ALLOYS OXY-FUEL RODS

W-1060

A copper coated, low carbon steel rod which is widely used on mild steel. It offers good ductility and machinability.

Applications:

- Low carbon steel
- Automotive repair
- Ornamental art

Procedure:

- Use a neutral flame; however a very slight excess of acetylene assures the absence of an oxidizing flame which adversely influences weld quality
- Flux is not needed but "puddling" of the molten weld metal will bring any scale or impurities to the surface

Composition:

C - 0.08	Cu - 0.30
Mn - 0.05	Cr - 0.20
Si - 0.10	Ni - 0.30
P - 0.035	Mo - 0.20
S - 0.040	Al - 0.02

Features:

- Tensile strength - 45,000 psi min.
- Conforms to AWS A5.2, R45

Stock No:

Sizes:	10 lb.	50 lb.
1/16" x 36"	W1060310	W106030
3/32" x 36"	W1060510	W106050
1/8" x 36"	W1060610	W106060
5/32" x 36"	W1060710	W106070
3/16" x 36"	W1060810	W106080
1/4" x 36"	W1060910	W106090

Packaging:

- 10 lb. tubes, 4 tubes per carton
- 50 lb. bulk cartons

W-1200

A high strength, bright finish, steel welding rod which will respond to heat treatment, flame hardening and cyaniding

Applications:

- Carbon steel pipes in power plants
- Process piping

Procedure:

- Use a neutral flame; however a very slight excess of acetylene assures the absence of an oxidizing flame which adversely influences weld quality
- Flux is not needed but "puddling" of the molten weld metal will bring any scale or impurities to the surface

Composition:

C - 0.15	Cu - 0.30
Mn - 0.90-1.40	Cr - 0.20
Si - 0.10-0.35	Ni - 0.30
P - 0.035	Mo - 0.20
S - 0.035	Al - 0.02

Features:

- Tensile strength - 65,000 psi min.
- Conforms to AWS A5.2, R60

Stock No:

Sizes	10 lb.	50 lb.
1/16" x 36"	W1200310	W120030
3/32" x 36"	W1200510	W120050
1/8" x 36"	W1200610	W120060
5/32" x 36"	W1200710	W120070
3/16" x 36"	-	W120080
1/4" x 36"	-	W120090

Packaging:

- 10 lb. tubes, 4 tubes per carton
- 50 lb. bulk cartons