

POLARIS® - MIG

Gas Metal Arc Welding (GMAW)

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

FEATURES

- 100,000 psi strength
- Good elongation
- Consistent quality welds
- Impact resistant
- Excellent out-of-position
- Copper flashed

CHARACTERISTICS

POLARIS-MIG is a deoxidized, copper-flashed manganese-silicon alloyed wire containing molybdenum. This alloy combination gives a high strength weld. The low carbon content provides good weldability and toughness.

POLARIS-MIG will provide consistent good quality welds while allowing for "fast freeze" weld puddle deposits. This makes it ideal for out-of-position welding. An excellent product for sulphur bearing and free machining steels.

POLARIS-MIG has superior high strength and good impact resistant qualities. Applications include construction equipment, farm implements, highly stressed components, pipe welding and low alloy steels.

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APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	GAS FLOW (Ft ³ /Hr)
.035" (0.9mm)	15-29	60-225	25
.045" (1.2mm)	17-34	100-300	30

SHIELDING GAS OPTIONS:

- 100% CO₂
- 98% Argon - 2% O₂
- 95% Argon - 5% O₂
- 75% Argon - 25% CO₂
- 80% Argon - 20% CO₂

