



**AMTEC W1265 FCG HIGH STRENGTH JOINING WIRE**  
**DC REVERSE POLARITY FLUX CORED WELDING WIRE**

**General Characteristics**

---

Amtec W1265 FCG is a high strength, gas-shielded, flux-cored wire designed for all position welding of carbon and alloy steels, low alloy steels such as T-1, HY-90, SS-100, 400, 500 and 600 brinell wear plate. This wire is also excellent for cast steel. In addition to offering excellent physical properties, weld deposits are highly crack resistant and can be used on joints that are under high restraint. Amtec W1265 FCG demonstrates very good low temperature notch toughness. In some applications, preheating can be reduced or eliminated. Deposits can be flame cut, and the welds are smooth and spatter free. W1265 FCG deposits an X-ray quality weld, and can be used for single or multi-pass welding.

**Procedure**

---

Clean the welding zone free from oil, rust and other contaminants. Use DC reverse polarity with a spray transfer, with gas coverage of 75% Argon/25% CO2 at the following settings:

	SPRAY ARC Flat		SPRAY ARC Vertical Up	
Size:	.045	1/16	.045	1/16
Amps	125-235	200-400	150-250	150-275
Volts	21-30	22-26	22-28	22-26
Gas	Ar/CO2	Ar/CO2	Ar/CO2	Ar/CO2
CFH	40-45	40-45	40-45	40-45
Stick-out	1/2" – 5/8"	1/2" – 3/4"	1/2" – 5/8"	1/2" – 3/4"

**Application**

---

Amtec W1265 FCG can be used for fabricating structural parts such as "I" and "H" beams, channel plates and pipe. This wire is ideal for joining wear plates. Excellent for use on construction and mining equipment such as dozer blades, buckets, crane and shovel booms, as well as for welding truck and bus frames.

---

**Wire Type:** Flux Cored, gas-shielded joining wire.

**Tensile Strength** 110,000 PSI

**Yield Strength** 89,000 PSI

**Elongation** 23%

**Charpy V Notch @ 0°F** 55 ft. lbs.

**Maximum number of passes:** no limit

**Deposits are** machinable

**Deposits can be** flame cut.

**Welds are** exceptionally smooth and spatter free and has outstanding weldability in all positions.

---

**Standard Packaging and Sizes:** .045 x 25 lb. spools  
1/16 x 25 lb. spools

---

**CONFIDENTIAL INFORMATION: Subject to Change without Notice**