



## EAGLE 866 FGS

Superior Gas Shielded Flux Cored All Position Wire  
for Joining Dissimilar Steels.

### APPLICATIONS

For buildup and joining of all grades of low alloy steels, tool steels, high alloy steels and carbon steels. Can be used for rebuilding shafts, forging dies, hot shearing blades, dies, punches, conveyor chains and debarker knives.

### PROCEDURE

DC reverse (+). Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use the lowest effective amperage while maintaining a 1/2 - 3/4 inch stick out length. Use the stringer bead technique for maximum strength.

### GENERAL CHARACTERISTICS

The **EAGLE 866 FGS** is an all position flux cored wire designed to produce superior weldments using 100% Co<sub>2</sub> or 75% - 25% Argon Co<sub>2</sub> gas. The soft stable arc and the fast-freeze weld puddle makes out of position welding easier to control and with very little spatter.

### TECHNICAL DATA

Tensile Strength: Psi	Approximate 118,000 – 120,000		
Elongation:	Approximate 24 –26%		
Current::	DC Reverse (+)		
Sizes: (IN)		.045	1/16
(MM)		1.20	1.60
Amperage:		120 – 400	180 – 400
Volts:		22 – 30	24 – 36
Gas Flow:	30 – 50 Cu feet per hour		
Shielding Gas:	75 Argon/25 Co <sub>2</sub> – 100% Co <sub>2</sub>		

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