



EAGLE 771 FGS

Gas Shielded Flux Cored All Position Wire For Joining Carbon Steel.

**CONFORMS TO AWS W48-18
CERTIFIED BY CWB E49IT-9M-H8**

APPLICATIONS

For welding mild and medium carbon steels. This wire is designed for welding pipe steels, fine grain steels, earth moving equipment, mining equipment and where single or multi pass welds are required on carbon steel.

PROCEDURE

Use DC Reverse [+] Polarity. Using 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 771 FGS** is an all position flux cored wire designed to produce superior weldments using mixed gas (80% Argon / 20% CO₂) or 100% CO₂ shielding 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: Approx. 79,000 psi
Yield Strength: Approx. 71,000 psi
Elongation: Approx. 29%

WELDING PARAMETERS

Current: DC Reverse [+] Polarity
Sizes: Inches .045 1/16
mm 1.20 1.60
Volts: 22 - 30 24 - 36
Amperage: 120 - 300 180 - 400
Gas Flow: 30 - 50 CFH
Shielding Gas: 80/20% AR/CO₂ or 100% CO₂



≡ HIGH QUALITY WELDING PRODUCTS ≡

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