

# Eagle-Arc

**Cored Welding Wire**

**Stainless & Mild Steel**





# Eagle-Arc Cored Wires

## Eagle-Arc 71

AWS A5.20, E71T-1C/1M

*Eagle-Arc 71 Flux Core* is an *all-position*, single or multi-pass wire for welding on mild and carbon steel. Features excellent feedability and operator appeal including; stable arc, low fume emissions and low spatter levels. Weld deposit exhibits good tie-in and geometry with self-peeling slag. This wire is designed for use with 100% CO<sub>2</sub> or 75-80% Argon, balance CO<sub>2</sub> mixed gases. Yields good penetration on light, medium or heavy gauge plate. 71 is a great choice for bridge structures, ship building, earth moving equipment and all general fabrication requirements.

### Typical Chemistry

C - 0.03  
Mn - 1.45  
Si - 0.30  
P - 0.015  
S - 0.010

### Typical Mechanical Properties

Tensile Strength - 86,000 psi  
Yield Strength - 81,000 psi  
% elongation - 26  
CVN 55 ft-lbs @ 0°F

### Recommended Parameters

Shielding gas Ar/CO<sub>2</sub> (75-80% Ar)  
or 100% CO<sub>2</sub>

| Amps | Flat    | Horizontal | vertical |
|------|---------|------------|----------|
| .045 | 120-320 | 120-250    | 120-260  |
| 1/16 | 150-400 | 200-400    | 160-280  |

Electrical stick-out 1/2 - 3/4" DC+

Actual Chemical Certification available on Request

## Eagle-Arc 70C

AWS A5.18, E70C-6M

*Eagle-Arc 70C Metal Core* is a gas shielded wire for single or multi-pass welding in the flat or horizontal position on mild steel. This alloy is virtually free of spatter and slag, drastically reducing clean-up time. The smooth, stable arc leaves an excellent bead appearance with superior tie-in. This alloy is formulated for high deposition and weld efficiency and will operate on shielding gas with 75-80% argon/balance CO<sub>2</sub>. Common uses include; Construction, erection and fabrication of heavy equipment, construction machinery and general fabrication of mild steel.

### Typical Chemistry

C - 0.04  
Mn - 1.55  
Si - 0.54  
P - 0.014  
S - 0.015

### Typical Mechanical Properties

Tensile Strength - 89,000 psi  
Yield Strength - 77,000 psi  
% elongation - 27  
CVN 29 ft-lbs @ 0°F to  
35 ft-lbs @ -20°F

### Recommended Parameters

Shielding gas Ar/CO<sub>2</sub> (75-80% Ar)

| Amps | Flat    | Horizontal |
|------|---------|------------|
| .045 | 160-350 | 180-360    |
| 1/16 | 220-450 | 280-450    |

Electrical stick-out 1/2 - 3/4" DC+

Actual Chemical Certification available on request

## Packaging

*Eagle-Arc* Cored Wires come in the following spool sizes:

.045 x 10, 33 & 44 lb spool

.052 x 33 & 44 lb spool

1/16 x 33 & 44 lb spool

**33 and 44 lb spools are hermetically sealed in vacuum packaging.**

For spools, coils and drums not shown  
please contact your Washington Alloy representative for quotation.



Washington Alloy maintains an  
**ISO 9001**  
certified quality management system

## WASHINGTON ALLOY DISTRIBUTION CENTERS

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