ESAB Gas Free

ESAB Gas Free is an all-position self-shielded flux cored welding wire for single pass applications. ESAB Gas Free produces smooth arc action, full slag coverage, easy slag removal, and low spatter. The use of DCEN (electrode negative) current minimizes the risk of burn-through. ESAB Gas Free is excellent for use on lap and fillet welds on thin gauge galvanized and mild steels in all welding positions. The availability of .030" (0.8 mm) diameter makes it possible to use this product on materials as thin as 18 gauge (1.2 mm). The wire is particularly suitable for thin gauge materials 0.030 - 3/16" (0.8-5.0 in.) in galvanised, zinc-aluminum carbon, or aluminised carbon steels. In structural fabrications, the product can be used where no seismic requirements are present.

Specifications	
Classifications	SFA/AWS A5.20 : E71T-14/GS

Welding Current	DC-
Alloy Type	C Mn
Shielding Gas	None

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Al**
0.23	0.7	0.4	1.98

Deposition Data					
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**TTW Dist.**	**Deposition Rate**
0.8 mm	75-120 A	14-17 V	2.0-10.0 m/min	-	0.4-1.8 kg/h
1 mm	80-120 A	15-17 V	2.06-9.95 m/min	9.5 mm	0.4-2.0 kg/h
1.2 mm	95-150 A	15-18 V	1.37-3.56 m/min	12.5 mm	0.4-1.2 kg/h