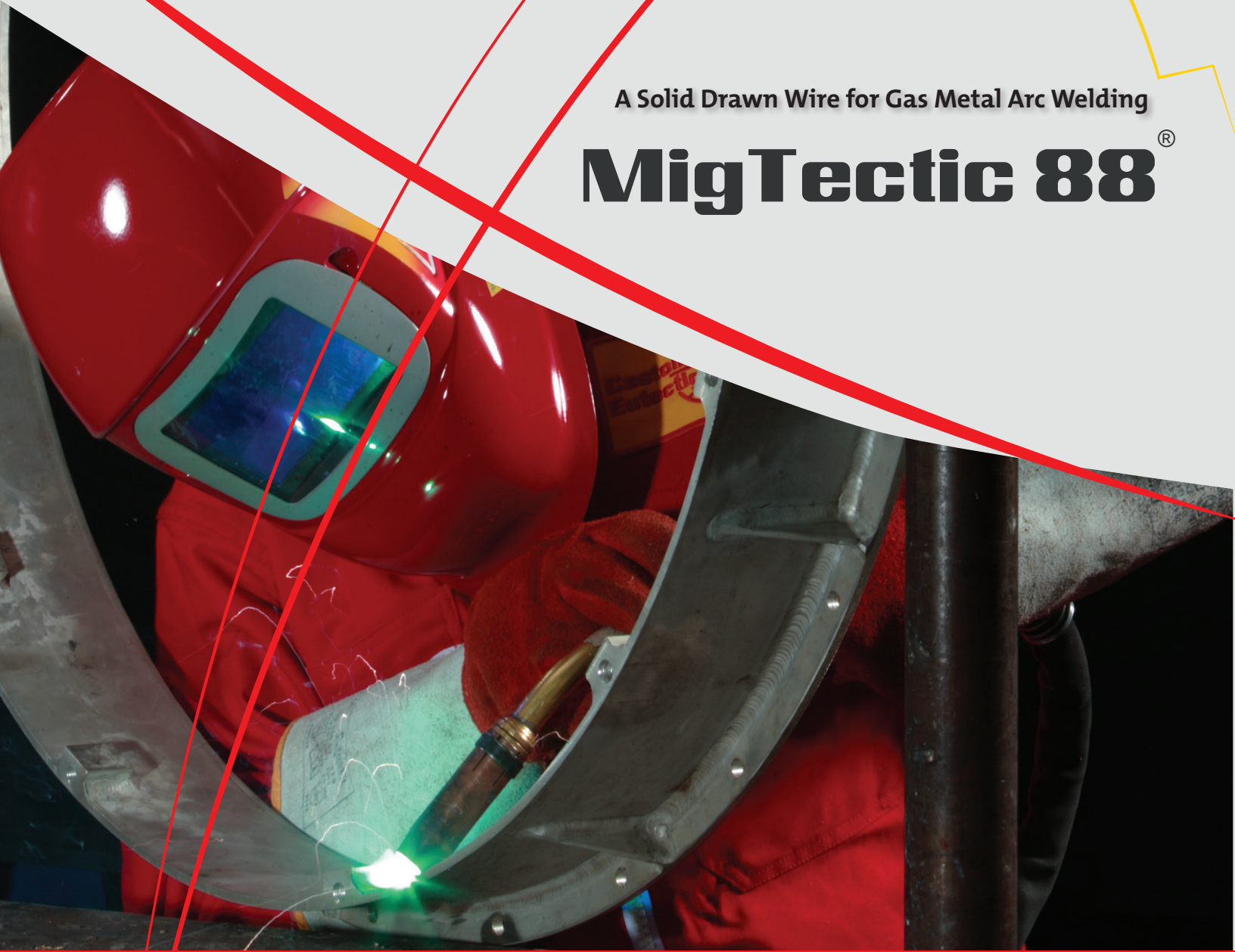




A Solid Drawn Wire for Gas Metal Arc Welding

MigTectic 88[®]



- Produces smooth deposits on light gauge steel and sheet metal
- Formulated for single and multi-pass welding of mild and plain carbon steels
- Excellent general purpose wire
- May be used for out-of-position, short-arc welding

MigTectic® 88

MigTectic 88 is formulated for single and multi-pass welding of mild and plain carbon steels. Wire uniformity assures smooth deposits on sheet metal and light gauge plate. Can be used for out-of-position short-arc welding.

TECHNICAL DATA

Operating Conditions	
Current Type:	DCEP (+)
Operating Conditions	
Tensile Strength:	72,000 psi
Yield Strength:	62,000 psi
Elongation (1=5d):	22%
Impact Strength:	Minimum Charpy V-notch 22 ft/lb @ -20°F:

SUGGESTED WELDING PARAMETERS (DCEP):

Diameter	Arc Mode	Voltage	Amperage	WFS (ipm)	Stick-Out	Shielding Gas
0.035"	Short	16 - 22	80 - 175	100 - 250	3/8"	*75% Argon - 25% CO ₂
0.035"	Spray	23 - 30	195 - 275	375 - 600	1/2"	**90% Argon - 10% CO ₂
0.045"	Short	17 - 22	145 - 220	125 - 200	5/8"	*75% Argon - 25% CO ₂
0.045"	Spray	27 - 31	260 - 340	330 - 500	5/8"	**90% Argon - 10% CO ₂

*100% CO₂ may also be used.

**98% Argon - 2% O₂ may also be used.

PROCEDURE FOR USE

PREPARATION: Clean weld area of scale and/or oxide. Check that the ground clamp is secure and in contact with a clean surface. Make sure all joints on thin gauge metals are tightly abutted with no gaps.

Note: Backing strips are useful in preventing burn-through.

TECHNIQUE: Be sure that the contact tip, gas diffuser, gas cup, and wire-drive rolls are suitable for the wire diameter and arc mode. Make a few practice runs to refine and optimize the Welding Parameters.

POST-WELDING: Allow parts to slow cool in still air.

TYPICAL APPLICATIONS

For general purpose sheet metal welding such as truck bodies, angle-bar and tube fit-up fabrications, farm implements, car body repairs, and other light gauge work.

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



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