

# Polaris® Ultra Flux Core

## Flux Core Arc Welding (FCAW -Wire)

For welding mild, medium, and high carbon steels. Also suitable for low alloy steels and wear resistant types.

### Features

- 95,000 psi Strength
- X-Ray Quality Welds
- Easy Slag Removal
- Runs Vertical Up Or Vertical Down
- 28% Elongation
- Welding Arc Unaffected By Drafts

### Characteristics

**Polaris Ultra Flux Core** is a self-shielded joining wire with excellent out-of-position welding characteristics. Ideal for single or multi-pass applications, it has low spatter, and a smooth spray transfer.

**Polaris Ultra Flux Core** will weld galvanized steels and contains deoxidizers to counteract the effects of contaminants such as light rust, oil or mill scale. Ideal for "suitcase" type wire feeders.

### Technical

Inches	.045	1/16	5/64
(mm)	(1.2)	(1.6)	(2.0)
Volts	12-20	13-20	15-21
Amps	75-220	108-270	120-300
Stick Out	1/8"-5/8"	1/4"-3/4"	1/4"-3/4"

Use Straight Polarity (DCEN)

### Shielding Gas Options

Self Shielded

### Applications

**Polaris Ultra Flux Core** applications would include tanks, structural steel, heavy equipment, machinery repair and railroad equipment.

We recommend **Gemini Anti-Spatter spray** for lasting protection of your contact tip and MIG nozzle (see chemical aids in Abrasives & Metal Working products section).

### Spool Size

- 25# Available in 5/64"
- 33# Available in .045 and 1/16"