



**FUSION™ ULTRABOND** is a seamless copper coated all position gas shielded flux cored welding wire used for joining higher strength steels with the weld deposit exhibiting high toughness even at low service temperatures. In order to improve sub-zero impact strength, FUSION™ ULTRABOND is 1% nickel alloyed. There is no need to change the parameters of FUSION™ ULTRABOND because high deposition rate welding can be carried out in all locations because the wire is seamless it picks up no moisture. It has exceptional wire feeding properties with good weldability and low spatter.

**FUSION™ ULTRABOND** has tremendously low hydrogen content, eliminating concern of hydrogen embrittled welds.

### Operational Characteristics / Welding Parameters

	0.045"			1/16"		
	Low	Med	High	Low	Med	High
Volts	20	24	26	23	26	29
Wire Speed	250 IPM	350 IPM	425 IPM	190 IPM	260 IPM	325 IPM
Stickout	1/2" - 5/8"	5/8" - 3/4"	3/4" - 1"	5/8" - 3/4"	3/4" - 1"	3/4" - 1"
Amps Produced	180-200	225 - 250	260 - 290	190 - 210	240 - 260	300 - 330

### Shielding Gas Position

Ar + 15 – 25% CO<sub>2</sub> OR 100% CO<sub>2</sub>  
All

TYPICAL ALL-WELD ANALYSIS			
C	Mn	Si	Ni
0.07	1.3	0.45	1.0

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES				
Shielding gas	Tensile	Yield	Elongation	Impact Strength
Ar + 15 – 25% CO <sub>2</sub>	88,500 PSI	79,500 PSI	25%	66 Ft Lbs @ -40F
100% CO <sub>2</sub>	84,000 PSI	75,000 PSI	25%	44 Ft Lbs @ -40F

### Typical Applications

- Construction steels
- Fine-grained steels
- Pressure vessel steels
- Pipe steels
- Shipbuilding steels

### Standard Sizes & Packaging

Diameter: 0.045" OR 1/16"  
Packaging: 33lbs. Spools