BOC
A Linde company

QuickFire

→ Technical Data Sheet

Mild Steel MIG Wire

Self-shielded FCAW Wire (Gasless).

Description

Quickfire GS is a self-shielded, flux-cored gasless wire that has been formulated to perform well in the downhand, vertical-up and overhead positions and also to make welds at high speed. The wire has been designed for those applications where the use of shielding gas is inappropriate and where impact toughness is not of prime concern. Quickfire GS is intended for single pass welding of thin-gauge mild and galvanised, aluminised or other coated steels ranging from 0.7 mm to 5 mm.

Quickfire GS operates on DC electrode negative and welds with a smooth running, soft, spray type transfer which minimises burn-through and facilitates welding joints with gaps or poor fit up. There is minimal spatter and together with the very wide operating window, good feedability and easy arc starting characteristics assures excellent operator appeal.

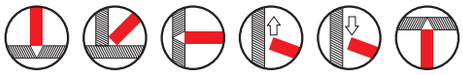
Application

Suitable for welding mild and medium tensile steels. Commonly used for light structural work, general fabrication and repairs.

Storage Recommendations

Store all wire spools in their original packaging in a controlled environment of less than 50% relative humidity.

Welding Positions



Recommended Shielding Gas

No gas required.

Specifications

Classifications	AWS/ASME-SFA A5.20: E71T-GS
	AS/NZS ISO 17632 B-T49 Z TG-1 NS
Welding current	DC -

Chemical Composition, wt% – Wire

	C	Al	Mn	Si	P	S	Ni	Mo
Typical	≤0.18	≤1.8	≤1.75	≤0.60	≤0.03	≤0.03	≤0.50	≤0.03

Mechanical Properties – All Weld Metal

Typical (as welded)	Self-shielded
Yield strength	≥400MPa
Tensile strength	490-660MPa
Elongation	≥22%

Packaging Data

0.9 kg Spool

Diameter	0.8 mm	0.9 mm	
Part No.	QFGS0809	QFGS0909	

4.5 kg Spool

Diameter	0.8 mm	0.9 mm	
Part No.	QFGS0845	QFGS0945	

Welding Parameters*

Diameter	0.8 mm	0.9 mm	
Current range (A)	60–150	90–220	
Voltage range (V)	15–24	16–30	

* PLEASE NOTE:
Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.

WARNING

Welding can give rise to electric shock, excessive noise, eye and skin burns due to the arc rays, and a potential health hazard if you breathe in the emitted fumes and gases. Read all the manufacturer's instructions to achieve the correct welding conditions and ask your employer for the Safety Data Sheets. Refer to www.boc.com.au or www.boc.co.nz

© BOC Limited 2023. BOC is a trading name of BOC Limited, a Linde company. Details given in this document are believed to be correct when published however please note that content may be changed without notice. RW 01/2023.