

Brutus[®] MIG

Gas Metal Arc Welding (GMAW – Wire)

For welding all steels—spring, mild, free machining, tool steel, stainless, and cast steel.

Features

- Superior Strength 130,000 psi
- High Elongation Up To 35%
- Ideal For Dissimilar Steels
- Crack Resistant
- Shock Resistant
- Corrosion Resistant
- Avoids Porosity
- Machinable Deposit

Characteristics

Brutus MIG combines the ease of gas metal arc welding with the exceptional properties of the **Brutus** alloys.

Brutus MIG can be used to join and build up all types of steel where a strong and ductile alloy is required. It is particularly useful in maintenance work where the exact type of steel may not be known and for joining dissimilar steels. Excellent as a build-up for final passes of tool steel or for shaft build-up.

Technical

Inches	.035	.045
(mm)	(0.9)	(1.2)
Volts	15-24	15-30
Amps	60-160	125-300
Gas Flow (ft ³ /hr)	15	20

Use Reverse Polarity (DCEP)

Shielding Gas Options

- 99% Argon – 1% O₂
- 98% Argon – 2% O₂
- 90% Helium – 7.5%
- Argon – 2.5% CO₂ (Trimix)

Application

- Base metal must be cleaned completely.
- Make sure the root pass fuses completely.
- Oxide film from each deposit must be brushed off with stainless brush between multi-pass welds.
- For high alloys and heavy sections preheat to 400°F (204°C).
- We recommend **Gemini Anti-Spatter spray** for lasting protection of your contact tip and MIG nozzle (see chemical aids in Abrasives & Metalworking products section).

Spool Size

- 2# Available in .035
- 10# Available in .035 and .045