WASHINGTON ALLOY CO.

DRUM
WELDING WIRE

CALIFORNIA MASSACHUSETTS NORTH CAROLINA TEXAS WASHINGTON

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American Welding Society Supporting Company Member

GAWDA GASES AND WELDING DISTRIBUTORS ASSOCIATION

WHY CHOOSE DRUMS VS. SPOOLS

EFFIENCY IS KING!

Successful production happens when cost of goods and labor costs converge efficiently
To avoid waste and hidden drains on process efforts. Time consuming tasks, equipment inefficiency and material loss are the main focuses to achieve improved welding performance overall.

GREATER PRODUCTIVITY / REDUCED DOWNTIME

When calculating welding costs, there are more factors to consider than simple wire cost.
Spool change-out time, equipment wear, accidental breakage and stub loss, etc. all play into the total cost of your welding operation.

Washington Alloy's Bulk Wire Drums efficiently address these issues, with drum sizes
Ranging from 250 LB up to 900 LB

Spool change-outs: A 550 LB drum eliminates multiple spool changes, saving 5 to 15 minutes of precious production time, per spool!
One 550 LB drum is equal to nearly Seventeen 33 LB spool, Thirteen 44 LB Spool and more than nine 55 or 60 LB coil changes. Some diameters are available in 880 LB drums, eliminating even more change-outs.

Equipment wear: Drums generally feed wire over 15 feet or more. Because of this, our wire is layered into the drum with a slight reverse twist, minimizing the cast and helix of the wire, reducing drag. This means less wear on drive-rolls, liners and contact tips.

Accidental breakage: When handling spools, invariably an operator may drop a spool and break the plastic flange or hub. Or when threading a new spool through the drive-rolls, the wire may slip from his fingers, allowing several layers to spring from the spool and tangle.

Wire Stub loss: At the end of a spool there will be up to 25 feet of wire still in the gun liner that must be removed and discarded before a new spool is loaded. With a drum, up to 16 of these "stubs" are not lost.

Labor: Each of these factors requires someone's time to handle the situation. Reducing this lost time is the greatest cost savings and the least interference with production.
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STANDARD SIZES AND WEIGHTS

.035 (0.9mm)	*250 lbs (mild steel)*
.045 (1.2mm)	*330 lbs (aluminum)*
.052 (1.4mm)	*500 lbs (stainless / solid)*
1/16 (1.6mm)	*550 lbs (mild Steel, flux cored)*
	880 lbs (mild Steel, flux cored)
	900 lbs (sub-arc)

**other sized drums available on special order*

DRUM SET-UP INSTRUCTIONS

1. Open the lid locking ring. Remove the lid and ring and Set them both aside for now.

*You will see a center cylindrical cardboard core with a plastic weight ring surrounding it. On the top you will see a triangle retainer bar attached to a large retainer spring extending down the core.

2. Remove the retainer bar, spring and desiccant bag hanging from the bar and set them aside.

3. DO NOT remove the plastic weight ring surrounding the core.

4. Attach the Quick-connect adaptor to the Top hole in the cone. The adaptor has a concave ceramic input on one end. This must face downward. Your feed wire will feed up through it and into the conduit.

5. Place the assembled cone on top of the drum and lock it in place with the same ring from step 1.
Now, attach the conduit end into the quick connect until it snaps in place.

6. Reach into the cone through the viewing flaps and unhook the feed wire from the eyelet on the plastic weight ring (some drums may have the feed wire tied off on the core instead of the ring). Being careful not to let go of the feed wire, snip off the end of the feed wire and push it up through the ceramic guide of the Quick-connect and into the conduit. Continue pushing it by hand until the wire comes out the other end of the conduit.

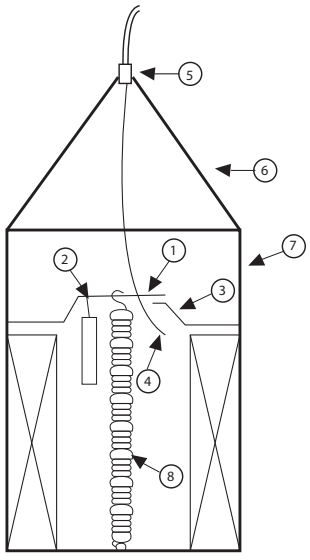
7. The Input Guide adaptor kit has a Quick-Connect for this end of the conduit. Do not connect it yet.

8. The adaptor will have a long pencil-like end that will fit the input guide on many machines. If the diameter is too small, you will find several fiber sleaves of various sizes. Mix and match these until you have the right combination for your machine's input guide diameter.

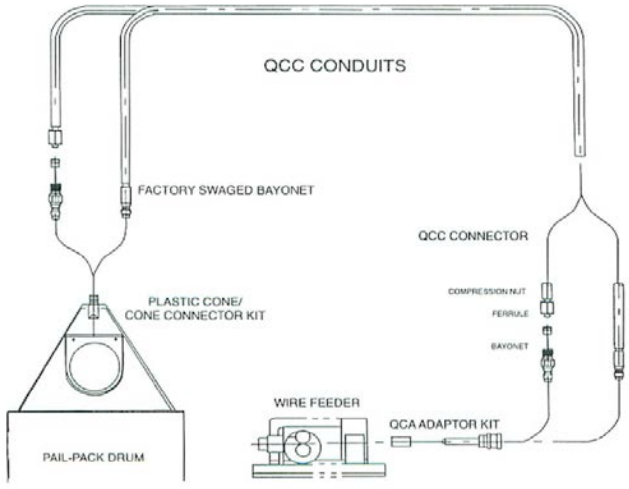
9. Once these are securely set in your welding machine, pull the feed wire from the conduit and push it through the input guide adaptor until the wire reaches the drive rolls. Adjust your drive roll tension to hold the wire firmly, then pull the conduit end up and snap it into the input guide Quick-Connect. From this point you will proceed as you would with a spooled wire. Once the wire feeds through your MIG gun you are ready to weld!

CAUTION: Do not remove the plastic weight ring. Do not tilt drum on its' side. Never overturn drum or roll it. If moving the drum on wheels or with forklift, leave the retainer bar, spring and plastic ring in place while the drum is moving.

DAMAGED DRUMS: If your drum is punctured with a forklift it will not feed properly at that point. If heavy objects are stacked on drums deforming the top, as long as the coils of wire and plastic ring are undisturbed, the drum should function in most cases.



1. Triangular Bar
2. Silica Gel
3. Plastic Pressure Ring
4. Starting Wire
5. Conduit Quick Connect
6. Cone
7. Drum
8. Large Spring



AVAILABLE ALLOYS AND SIZES

ITEM NO.

MILD STEEL
TC 70S-3 125 .035 X 550 LB Drum
TC 70S-3 129 .035 X 900 LB Drum
TC 70S-3 222 .045 X 550 LB Drum

TC 70S-6 120 .035 x 250 LB Drum
TC 70S-6 123V .035 x 550 LB Drum
TC 70S-6 145 .040 X 550 LB Drum
TC 70S-6 220 .045 X 250 LB Drum
TC 70S-6 223V .045 X 550 LB Drum
TC 70S-6 228 .045 X 880 LB Drum
TC 70S-6 23 .052 X 550 LB Drum
TC 70S-6 238 .052 X 880 LB Drum
TC 70S-6 26 1/16 X 550 LB Drum
TC 70S-6 268 1/16 X 880 LB Drum

SUB-ARC
CW-EM12K 279 3/32 X 900 LB Drum
CW-EM12K 289 1/8 X 900 LB Drum
CW-EM12K 299 5/32 X 900 LB Drum

CHOSUN FLUX CORED
CSF-71T 26 1/16 X 550 LB Drum

CSF-71LF 20 .045 X 550 LB Drum
CSF-71LF 235 .052 X 550 LB Drum
CSF-71LF 26 1/16 X 550 LB Drum

LOW ALLOY
TC 100S-1 123 .035 X 550 LB Drum
TC 100S-1 175 .045 X 550 LB Drum
TC 110S-1 175 .045 X 550 LB Drum
TC 120S-1 123 .035 X 550 LB Drum
TC 120S-1 175 .045 X 550 LB Drum
TC 120S-1 20 .052 X 550 LB Drum

METAL CORE WIRE
TCD 70C-6M 123 .035 X 550 LB Drum
TCD 70C-6M 223 .045 X 550 LB Drum
TCD 70C-6M 26 1/16 X 550 LB Drum

EAGLE-ARC 719
TCC EAGLE-ARC 719 20 .045 X 550 LB Drum
TCC EAGLE-ARC 719 26 1/16 X 550 LB Drum

SILICON BRONZE
TCU SB 120 .035 X 250 LB Drum (SILICON BRONZE)
TCU SB 223 .045 X 550 LB Drum " "

ALUMINUM
TA 4043 238 3/64 X 330 LB Drum
TA 5356 238 3/64 X 330 LB Drum

STAINLESS STEEL
TS308L-SI 121 .035 x 500 LB Drum
TS308L-SI 223 .045 x 500 LB Drum

TS309L-SI 121 .035 x 500 LB Drum
TS309L-SI 22 .045 x 500 LB Drum

**other sized drums available on special order*

AVAILABLE ACCESSORIES

ITEM NO.

TC CONE 20" DOME AND 180" CONDUIT, COMPLETE SET W/CONNECTORS

TC CONE 09 20" DOME AND 120" CONDUIT, COMPLETE SET W/CONNECTORS

TC CONE 20" DOME AND 72' CONDUIT, COMPLETE SET W/CONECTORS

TC CONE 10 20" CONE ONLY FOR DRUM PACK

TC CONE 11 23" CONE ONLY FOR DRUM PACK

TC CONE 04 26" CONE ONLY FOR DRUM PACK

TC CONE 12 23.5" OCTAGONAL HOOD W/QUICK CONNECT COUPLER - DOME ONLY

TC CONE 07 24" CONDUIT ONLY FOR DRUM PACK

TC CONE 01 72" CONDUIT ONLY FOR DRUM PACK

TC CONE 08 84" CONDUIT ONLY FOR DRUM PACK

TC CONE 02 120" CONDUIT ONLT FOR DRUM PACK

TC CONE 05 180" CONDUIT ONLY FOR DRUM PACK

TC CONE 03 240" CONDUIT ONLY FOR DRUM PACK

TC CONE 15 300" CONDUIT ONLY FOR DRUM PACK

TC CONE 14 DOME CONNECTOR KIT QUICK CONNECT

TC CONE ADAPTOR KIT

TC CONE CONDUIT COOPLER