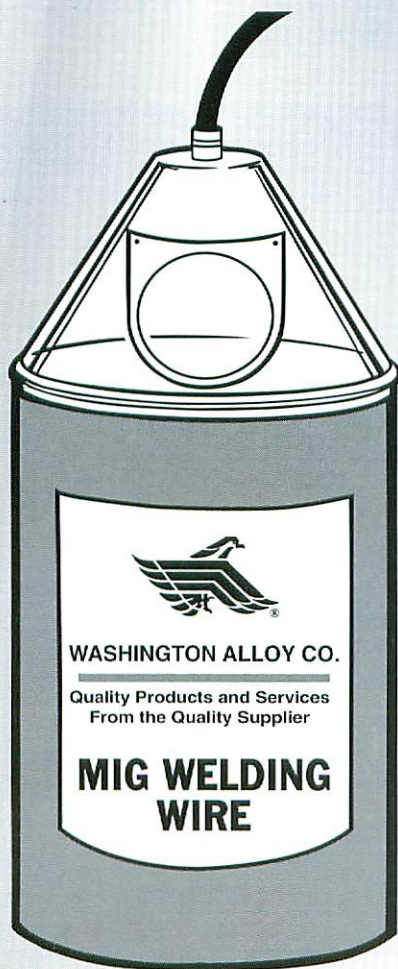# WASHINGTON ALLOY CO.

**Quality Products and Services
From the Quality Supplier**

PAIL-PACK DRUM
CONTINUOUS WIRES FOR MIG WELDING

- **A bulk wire system for robotic, automatic and semi-automatic applications**

- **Straight, twist-free wire system increases productivity and saves $$$$**

- **Simple, quick-connect conduit system gets the wire from the Pail-Pack Drum to the wire feeder cleanly and safely**

WASHINGTON ALLOY CO.

Quality Products and Services
From the Quality Supplier

**MIG WELDING
WIRE**

INCREASE PRODUCTIVITY BY REDUCING DOWNTIME

Washington Alloy Pail-Pack Drums contain 500 lbs of wire. That is equal to nearly 17 standard 30 lb. MIG spools and more than 8 standard 60 lb. coils. If you do the math on the enclosed chart, then you can calculate how much time you will save, just by eliminating that many changes of spools or coils. Add in the time and replacement cost you save by NOT having to change conduits, liners or nozzles and there is an even greater savings. Spend more time welding and less time changing spools, coils or equipment.

REDUCE WEAR AND TEAR ON YOUR CONDUIT AND WIRE FEEDER

Pail-Pack Drum wire is twist-free because it has no helix or cast. There is no "twisting or turning" of the wire as it travels through the conduit or as it enters the wire feeder. This feature reduces wear and tear on the conduit and wire feeder too! There will be no feed roll slippage or copper flaking problems to deal with. If you are doing semi-automatic welding, you will also save $$$$ on nozzles.

EASY TO SET UP

Washington Alloy Pail-Pack Drum wire is so easy to set-up and the cone assembly can be used over and over again – on hundreds of Pail-Pack drums. Using our QCC Conduit system gets the wire from the Pail-Pack Drum to the wire feeder safely and cleanly. The easy to use assembly offers quick changes and hookups.

GREATER ARC PERFORMANCE

Since Washington Alloy Pail-Pack Drum wire is twist-free, there will be no "arc-wandering." This is especially beneficial in robotic applications where precise and cosmetically appealing seam joints are desired, such as found in the manufacturing of automobile bodies, boat building or similar applications.

Washington Alloy Pail-Pack Drum wire offers performance reliability and optimum efficiency for each welding station.

PAIL-PACK DRUM WIRE IS AVAILABLE FOR MANY GRADES OF SOLID AND FLUX-CORED WASHINGTON ALLOY WIRES.

GO WITH THE BEST — WASHINGTON ALLOY PAIL-PACK DRUM WIRE!!!!

SAVINGS OF PAIL-PACK DRUMS VS. SPOOLS

		33 LB. SPOOLS	PAIL-PACK DRUMS
A.	Wire consumption (lbs)	20,000	20,000
B.	Package size (lbs)	33	500
C.	Number of package changes (A ÷ B)	606	40
D.	Package change time (min.)	10	15
E.	Total downtime for package changes (C x D ÷ 60)	101 hrs.	10 hrs.
F.	Total cost of welding station* ($/ hr.)	$75	$75
G.	Total cost of downtime (E x F)	$7575	$750
H.	Cost of wire (price per lb. x A)	$17,142	$17,142
I.	Total variable costs (G+ H)	$24,717	$17,892

TOTAL SAVINGS OF $6825 (per 20,000 lbs.)

Based on **YOUR** current cost of wire, we suggest you calculate the savings you will have by switching to Washington Alloy Pail-Pack Drums.

A.	Wire consumption (lbs. or kgs.)	_____	_____
B.	Package size (lbs or kgs.)	_____	_____
C.	Number of package changes (A ÷ B)	_____	_____
D.	Package change time (minutes)	_____	_____
E.	Total downtime for package changes (C x D ÷ 60)	_____	_____
F.	Your total cost for the welding station* ($/hour)	_____	_____
G.	Total cost of downtime (E x F)	_____	_____
H.	Cost of wire (price per lb. or kgs. x A)	_____	_____
I.	Total variable costs (G + H)	_____	_____

TOTAL SAVINGS OF _____

* Labor, overhead, plant and equipment allocation per station.

SET-UP INSTRUCTIONS FOR THE PAIL-PACK DRUM

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

2. Reach into the pail-Pack Drum and remove the large spring. (Do not leave it in the Pail-Pack Drum).

3. Remove the triangular bar sitting on top of the Plastic Pressure Ring and that the spring was attached to. Remove the Silica Gel bag. (Do not leave the triangular bar or the silica gel bag in the Pail Pack Drum).Do NOT remove plastic pressure ring.

4. Attach the cone connector kit to the cone and the conduit. Attach the QCA Adaptor kit to the conduit and the wire feeding mechanism.

5. Now, place the assembled cone on top of the Pail-Pack Drum and lock it into place with the same lid locking ring that you set aside when opening the Pail-Pack Drum.

6. Now, reach into the cone through the covered opening and unhook the wire from the inside eyelet of the Plastic Pressure Ring. "Trim" the end of the wire and feed it up through the conduit attached to the top of the cone. Continue feeding the wire through until it reaches the end of the conduit liner and into the wire feeder.

7. Note: The wire pulls up through the center of the plastic pressure ring – make sure of this!
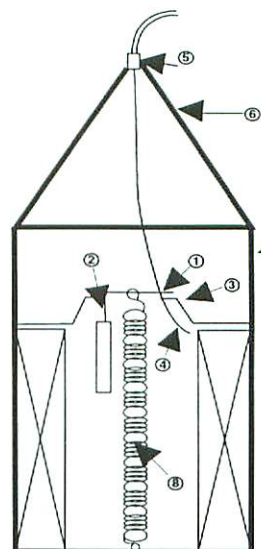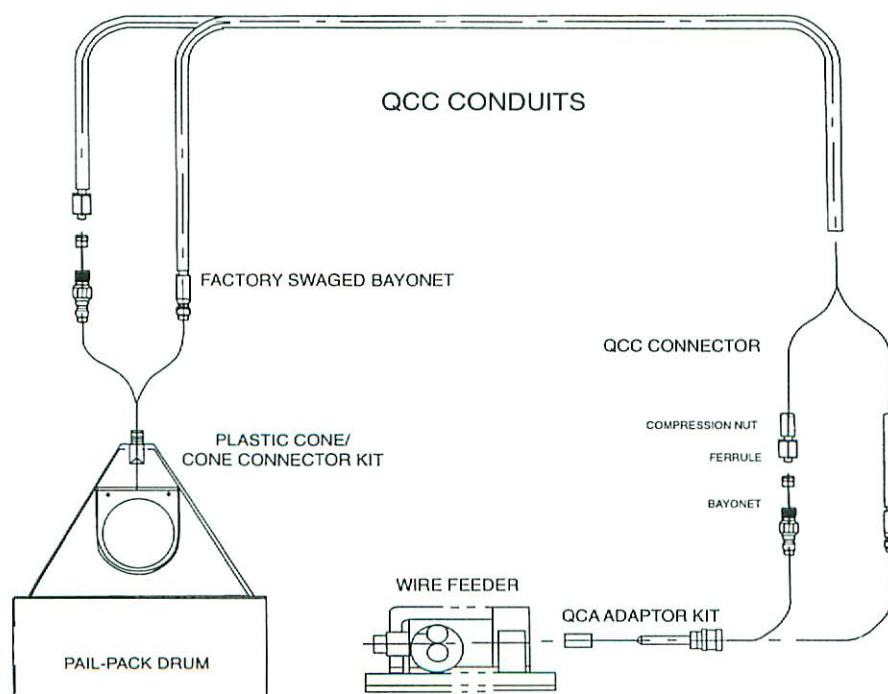
① Triangular Bar
② Silica Gel
③ Plastic Pressure Ring
④ Starting Wire
⑤ Cone Connector Kit
⑥ Cone
⑦ Pail-Pack Drum
⑧ Large Spring

Do not attempt to remove the Plastic Pressure Ring. The wire pulls through the center of it!

CAUTION: Pail-Pack Drums need to be handled carefully. Do not tilt the drums for loading or unloading and never overturn or roll them. Punctured Pail-Pack Drums will not work properly. Move them by lifting and only with the cover on and with the large spring and triangular bar securely in place. Only then can these Pail-Pack Drums be moved around.

QCC CONDUITS

QCC CONDUITS

FACTORY SWAGED BAYONET

PLASTIC CONE/
CONE CONNECTOR KIT

QCC CONNECTOR

COMPRESSION NUT

FERRULE

BAYONET

WIRE FEEDER

QCA ADAPTOR KIT

PAIL-PACK DRUM

CONE ASSEMBLY IS SOLD SEPARATELY AND INCLUDES:
(1) 20" plastic cone
(1) cone connector kit
(1) QCC conduit 120" (10 ft.)* (standard)
(1) QCA adapter kit

* Other lengths of conduit are available upon request and at variable cost(s).However the shorter the conduit, the better the performance of the wire feed.

PAIL-PACK DRUM DIMENSIONS:

20½" diameter x 32" high

AVAILABLE SIZES AND WEIGHTS:

.035	.045	.052	.062
(0.9mm)	(1.2mm)	(1.4mm)	(1.6mm)

500 lbs (227 kgs) per Pail-Pack Drum
4 drums per pallet/skid.

*PRODUCTS AVAILABLE IN PAIL-PACK DRUMS

Washington Alloy 70S-2	Washington Alloy 70T-1
Washington Alloy 70S-3	Washington Alloy 71T-1
Washington Alloy 70S-6	Washington Alloy 71T-11
Washington Alloy 80S-D2	Washington Alloy 71T-GS

* Most stainless steel flux-cored wires and stainless steel solid wires are also available.

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