

Perfect Pass

Welding Products

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XRS 99

Data Sheet

**NOW
FEATURING
EXTRA RAPID
START TIP**

NEW AND IMPROVED

**SUPERIOR ALL-POSITION
CONTROLLED-HYDROGEN ELECTRODE
FOR PROBLEM STEELS
AC OR DC REVERSE (ELECTRODE+)**

GENERAL CHARACTERISTICS:

XRS 99 is a high strength and highly crack resistant electrode for welding of medium carbon and cast steel. Has very good ability to withstand deformation in rigid structures where high welding stresses exist. Has excellent welding characteristics in all positions and produces sound crack free deposits.

APPLICATIONS:

XRS 99 is recommended for repair welding of a wide range of mining and construction equipment, for joining of steel frames, crusher parts and cast steel components. Outstanding for welding steels sensitive to cracking. Also suitable for build up and repair of steel castings.

PROCEDURE:

Clean surface contaminants from weld area. By observing good welding practices and electrode care associated with low hydrogen electrodes and taking into consideration heat input and the control of hydrogen by maintaining a short arc length in the welding process, excellent results can be consistently attained. To meet impact strength requirements preheat and postheat may be recommended on heavier sections to reduce hardness and control stress in the weld area which will further enhance the weld deposits resistance to underbead cracking.

TECHNICAL DATA:

Tensile Strength	Yield Strength	Elongation	ft/lbs	Impact Strength	Temperature
80,000-85,000 psi	45,000-77,000 psi	28-34% - 2"	150-173	joules	Ambient
555-590 MPa	450-535 MPa		55-62	203-234	-40°C

OPERATING PARAMETERS

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

RECOMMENDED AMPERAGE

Diameter:	2.50mm 3/32"	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"	6.0mm 1/4"
Amperage	80-100	120-140	150-190	200-250	280-340

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