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# XR 99

## Data Sheet

# SUPERIOR ALL-POSITION CONTROLLED-HYDROGEN ELECTRODE FOR PROBLEM STEELS

**AC OR DC REVERSE (ELECTRODE+)**

## *GENERAL CHARACTERISTICS:*

XR 99 is a high tensile strength ferritic electrode. This high quality, all position, low amperage electrode features rapid deposition. Deposits have good ductility, are dense, crack-free, and of x-ray quality. XR 99 is excellent for steels sensitive to cracking when welded with conventional mild steel electrodes.

## *APPLICATIONS:*

For "tramp" and "problem" steels high in sulfur, phosphorus, or other elements added to improve the machinability of Th. steel. For fabrication of "H" and "I" beams, angle and channel iron, pipelines, and all other steel structures. For circular tube to plate welds, and other type joints subject so stress and strain.

## *TECHNICAL DATA:*

Tensile Strength ..... up to 80,000 psi (552 N/mm$^2$)
Current ..... AC or DC reverse polarity (electrode+)

| Amperage | | 60-100 | 110-150 | 140-200 | 220-280 | 300-375 |
|---|---|---|---|---|---|---|
| | (in) | 3/32" | 1/8" | 5/32" | 3/16" | 1/4" |
| | (mm) | 2.5 | 3.25 | 4.0 | 5.0 | 6.0 |

## *PROCEDURE:*

Area to be welded should be cleaned thoroughly. Surface contamination must be removed and bevel or chamfer where required. Maintain close arc length. Vertical joints should be welded from bottom up, using rapid weave technique. Do not whip. Use drag technique to make horizontal fillet welds. Slag is easily removed.

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