



Welding Products

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B80

Data Sheet

FOR JOINING ALL COMMON MILD STEELS

DESCRIPTION:

AC/DC coated mild steel electrode designed for all position welding of mild steels.

APPLICATIONS:

- For joining angle iron, channel, T, perforated steel sheet, expanded metal, sheet metal and all other shapes and forms of mild steel used in maintenance.
 - For repairing and fabricating machine guards, covers, housing, ducts.
 - For welding floor plate, diamond plate, black iron, bulkheads and partitions.
 - For all types of maintenance and repair welding of mild steel.
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HOW TO USE:

Equipment: any constant current stick welding power source regardless of open circuit voltage, both AC and DC.

PROCEDURE:

Clean surface. Use any technique desirable - short, medium, or long arc; stringer beads or weave beads - in all positions. Remove slag between passes.

TYPICAL PROPERTIES:

Tensile strength: 85,000 psi

RECOMMENDED AMPERAGES:

ELECTRODE SIZE

1/16"
5/64"
3/32"
1/8"
5/32"
3/16"

RECOMMENDED AMPERAGE RANGE

20 - 50 AMPS
40 - 60 AMPS
50 - 100 AMPS
70 - 126 AMPS
90 - 160 AMPS
110 - 200 AMPS