

Perfect Pass

Welding Products

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EO8600

Data Sheet

**DESCRIPTION:**

All position AC/DC coated electrode, depositing high alloy weld metal, designed to produce crack-free deposits having very high mechanical properties. Superior performance of limited input AC welding machines.

**APPLICATIONS:**

- Weld all carbon and alloy steels - low-medium-high in all positions, under all conditions, including dissimilar combinations.
- Weld all tool steels, manganese steels and specialty steels in thick-to-thin designs.
- Will actually deposit using non-commercial AC or DC power sources having very low open circuit voltage characteristics.
- Drag or touch welding technique may be used, particularly in fillets without slag interference.

**HOW TO USE:**

**Equipment:** Any constant-current AC Transformer or DC generator-rectifier providing minimum 55 volts open circuit.

**Procedure:** Clean surface. Adjust amperage within recommended range and deposit electrode maintaining short to medium arc length. Tilt electrode 15° in direction of travel. For rapid filleting, raise amperage slightly and drag weld, inclining the electrode 45° in the direction of travel. Back-whip craters and remove slag between passes.

**TYPICAL PROPERTIES:** Tensile Strength: 128,000 UTS

Weld metal is ferro-magnetic and will not appreciably work harden in surface.

**RECOMMENDED AMPERAGES:**

ELECTRODE SIZE	RECOMMENDED AMPERAGE RANGE
1/16"	25 - 55 amps
3/32"	40 - 90 amps
1/8"	60 - 130 amps
5/32"	90 - 160 amps
3/16"	130 - 200 amps

