



Perfect Pass is a line of quality-first maintenance & repair alloys.
WIRES • POWDERS • STICK ELECTRODES

8009

DATA SHEET

GENERAL CHARACTERISTICS:

Perfect Pass 8009 has excellent high temperature strength and oxidation resistance. Use this electrode for joining and cladding or as a wear facing electrode. The deposit remains strong and ductile over a wide temperature range.

APPLICATIONS:

Use when welds are to be subjected to thermal cycling. Use where good weld ductility is a must when joining or repairing heavy sections. The electrode is used on heat treating equipment, cryogenic equipment, and similar combinations of nickel alloys, stainless steels, Inconels, Monels, and combinations of these to steel and to each other.

WELDING PROCEDURE:

Clean the weld zone of any grease, oil, rust, or any other contaminants by grinding. Joint should be 25% more than conventional joints to allow for the low penetration characteristics of this electrode. Use stringer beads or a slight weave. Remove slag between passes. If weld is to be used in high temperature, extra care must be taken to remove all slag.

TENSILE STRENGTH	Up to 85,000 psi
ELONGATION	30%
HEAT RESISTANCE	EXCELLENT
CRYOGENIC USE	EXCELLENT
SCALLING RESISTANCE	EXCELLENT
CURRENT	DC Reverse Polarity (Electrode +) Limited use on AC Equipment

DIAMETER	AMPS
3/32" (2.5MM)	80-120
1/8" (3.25MM)	120-150
5/32" (4.0MM)	130-180



PO BOX 612
GREENACRES, WA 99016
AGRITOOLSUPPLY.COM
800.321.5460

4230 E TRENT AVE
SPOKANE, WA 99202
A-LCOMPRESSEDGASES.COM
509.534.1595

