



Perfect Pass is a line of quality-first maintenance & repair alloys.

WIRES • POWDERS • STICK ELECTRODES

XRS-99

Premium, Low Hydrogen, Moisture Resistant Electrode

GENERAL CHARACTERISTICS:

Perfect Pass XRS-99 is an all position, low hydrogen electrode designed for the welding of steels, susceptible to certain forms of under-bead and embrittlement cracking. Also suitable for general fabrication and repair of most low-alloy and carbon steels. Deposits have good ductility, are dense, crack-free, and of x-ray quality.

APPLICATIONS:

Perfect Pass XRS-99 can be used on a wide variety of plain carbon and low-alloy steels. These steel grades are typically encountered in the mining, construction, and civil engineering industries. Applications would be heavy-duty equipment frames, chassis, truck bodies, ore cars, and general fabrication with H and I beams.

WELDING PROCEDURE:

PREPARATION: Clean weld area of scale and/or oxide. Bevel or chamfer heavy sections to have either a single or double 60° “V” prep. A nominal preheat of 150°F is advised if part is below 40°F or over 1” thick. For higher carbon steels, higher preheats will be needed.

TECHNIQUE: All low-hydrogen electrodes should be used with non-contact, short arc gap technique. An arc start-block is recommended to prevent starting porosity. Deposit stringer beads or 2x – 3x weave beads.

TECHNICAL DATA:

Typical Tensile Strength:	76,000 psi (524 N/mm ²)
Typical Yield Strength:	68,000 psi (470 N/mm ²)
Elongation (1=5d) min.:	31%
Typical Reduction Area:	75%
Typical V-Notch Impact:	70 ft/lbs @ -50°F
Current/Polarity:	DCEP (+) or AC (-)

DIAMETER:	3/32” (2.4mm)	1/8” (3.2mm)	5/32” (4.0mm)
AMPERAGE:	60-100	110-150	140-220



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