



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

WIRES • POWDERS • STICK ELECTRODES

S-80

“OLD RUSTY”

DATA SHEET

ALL-POSITION ELECTRODE FOR WELDING RUSTY, CONTAMINATED AND HEAVILY MILL-SCALED STEELS

GENERAL CHARACTERISTICS:

Perfect Pass S-80 has a deeply penetrating arc which effectively cuts through surface contamination. Arc control is easy which helps in non-stop welding. Because it can be used at very low amperage settings, poor fit-up assemblies are easy to repair.

APPLICATIONS:

Use for mild and plain carbon steels which cannot be effectively cleaned such as machine guards, farming equipment, galvanized parts, painted tanks, oil-contaminated steel housing, etc.

WELDING PROCEDURE:

Clean the weld area of any scale and/or oxide. Angle prepping normally involves close-butts and infrequent bevel preparations. Preheating is generally not required when using S-80 as it is typically used with mild and plain-carbon steels. A “contact technique” is recommended for fillet welding and a reasonably small arc-gap for flat, bead-on-plate welding. Deposit stringer beads or 2x to 3x weave beads. Do not weave more than three times the electrode diameter.

TENSILE STRENGTH	80,000 psi
YIELD STRENGTH	70,000 psi
ELONGATION (1=5d) min.	25%
CURRENT & POLARITY	DCEP (+) and AC

DIAMETER	AMPS
3/32” (2.5MM)	45-75
1/8” (3.2MM)	70-120
5/32” (4.0MM)	95-140



PO BOX 612
GREENACRES, WA 99016
AGRITOOLSUPPLY.COM
800.321.5460

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

