



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

WIRES • POWDERS • STICK ELECTRODES

E/O 8600 DATA SHEET

GENERAL CHARACTERISTICS:

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.

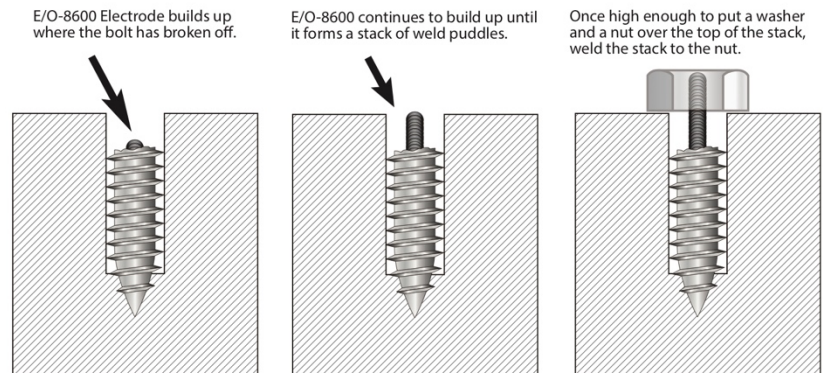
APPLICATIONS:

- 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 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.

MECHANICAL PROPERTIES:

- Tensile Strength: 128,000 UTS
- Current and Polarity: DC Reverse polarity
- **Electrode Size:**

1/16"	Amperage: 25-55
3/32"	40-90
1/8"	60-130
5/32"	90-160
3/16"	130-200



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 filletting, raise amperage slightly and drag weld, inclining the electrode 45° in the direction of travel. Back-whip craters and remove slag between passes.



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