



# General Purpose Electrode for Welding Low Carbon Steels in any position

**AC or DC EITHER POLARITY**

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## GENERAL CHARACTERISTICS:

This electrode has been designed to operate on almost any AC or DC welding machine, even when the open circuit voltage is very low. The special coating protects the weld deposit from adverse conditions normally encountered in maintenance repair welding. Low amperage requirement controls distortion when welding thin sheet metal; spatter is kept to a minimum. Ideal for field repair work and out of position welding.

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## APPLICATIONS:

Fabrication of thin, medium, heavy and dissimilar gauge mild steel. Sheets, plates, angle iron, beams, pipes and machine parts can be welded in all positions. Also used for filling holes and build-up of over-machined and worn surfaces. Commonly used on applications requiring short, intermittent, and spot welds because of the outstanding restarting characteristics.

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## TECHNICAL DATA:

Tensile Strength	..... up to 80,000 psi (56 kg/mm <sup>2</sup> )					
Yield Strength	..... up to 68,000 psi (47 kg/mm <sup>2</sup> )					
Elongation %	..... Approx. 24					
Current	..... AC or DC either polarity					
Amperage	20-50	25-60	35-80	65-125	90-160	120-210
(in)	1/16	5/64	3/32	1/8	5/32	3/16
(mm)	1.5	2.0	2.5	3.25	4.0	5.0

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## PROCEDURE:

Remove as much foreign material as practical from the weld area. DC reverse polarity (electrode +) produces deep penetration; DC straight polarity (electrode -) will have limited penetration and a flatter bead. AC prevents arc blow. A medium arc length should be maintained with either stringer or weave beads. Slag is easily removed with a light chipping hammer.

Manufactured by **AmAlloy Industries®**  
To Order - Call: **507-373-1677** or **800-735-3040**  
or E-mail: [amalloyindustries@gmail.com](mailto:amalloyindustries@gmail.com)  
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