



High Strength, All-Position Electrode for Welding on Extremely Dirty or Rusty Mild Steels

AC or DC EITHER POLARITY

GENERAL CHARACTERISTICS:

The special coating on AM-606 allows it to weld over extremely dirty, greasy, oil soaked and/or rusty steels. It can also weld over its own slag without causing inclusions or slag interference. The low amperage capability make it excellent for poor fit-up applications and use on low open circuit voltage buzz boxes. It is not necessary to chip slag between passes.

APPLICATIONS:

Ideal for production, as well as maintenance applications where poor fit-up is encountered. The ability to maintain a good arc at low amperages also makes it excellent for applications involving light gauge steel. AM-606 easily welds on steel beams and girders that have many coats of paint without developing porosity or defective welds. Welds are also easily made on equipment or machines that are covered with grease and sand and can't be cleaned before welding. Designed for pipe line welding, tank fabrication, machine and automotive repair, as well as general construction and fabrication.

TECHNICAL DATA:

Tensile Strength				up to 85,000 psi
Yield Strength				up to 69,000 psi
Elongation %				Approx. 25
Current				AC or DC either polarity
Amperage	20-100	30-140	15-175	
(in)	3/32	1/8	5/32	
(mm)	2.5	3.25	4.0	

PROCEDURE:

If possible, clean the weld areas as much as is practical. Set the amperage to the specific requirements. If an edge build-up is required or it is thin steel, use the lower end of the amperage range. If heavy penetration is required or the weld area is extremely dirty, use the higher end of the amperage range. A close to medium arc gap should be maintained. Slag chipping is recommended, but not necessary on multi-pass applications.

Manufactured by **AmAlloy Industries®**
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