

## AM-700

### HOW TO EASILY REMOVE BROKEN STUDS, DRILLS AND TAPS AND REPAIR HARD TO WELD STEEL PARTS

Have you ever spent hours trying to remove a broken stud or bolt, or a tap or drill that broke off below the surface, deep in the hole? Using **AM-700**, these broken studs or tools now can be easily removed in minutes (Fig. 1).

For hole diameters up to 3/8", use **AM-700** 3/32" diameter. For larger holes, use the 1/8" diameter electrode. Use the amperage recommended on the package label. Place the electrode in the holder and strike an arc on the broken stud. You must strike the arc in the center and not on the edge of the stud (Fig. 2). Once the arc is established, keep the electrode tip tight into the puddle and in the center of the hole. The special slag created from **AM-700** will fill the threads of the hole and keep the deposit from fusing to it, which is the secret of this technique. Continue holding a steady arc in the center of the hole as the deposit works its way to the surface. When you get near the top, be sure you do not let the puddle fuse to the top edge of the hole (Fig. 3). You may have to stop welding for a few seconds when you get near the top to let the weld deposit cool a bit. This will help keep the deposit from welding onto the edge. If you do stop, after the weld cools, chip only the center of the slag away to restrike the arc.

Continue the deposit until you have a knob sticking up above the part surface (Fig. 3). Chip the slag away from the knob and place a nut over it. Weld the nut to the knob from the inside of the nut (Fig. 4). Be sure the knob is high enough so that you do not weld the knob to the surface of the workpiece. Now put a wrench on the nut and remove the stud – or tap or drill (Fig. 5). If you strike the initial arc on the center of the broken stud, you will have no trouble removing it. In most cases, the whole process only takes about five minutes.

The special flux coating and high alloy core wire used in the manufacture of **AM-700** make it the best electrode you can use wherever strong welds are needed on tough to weld steels. You can weld leaf springs from trucks, stainless steel containers, steel gears, and shafts, and even unknown steels. **AM-700** has very high strength for building up bucket edges, plow points, snow plow edges, etc. This unique electrode can be used on all stick electrode welding machines, even the small limited capacity AC machines.

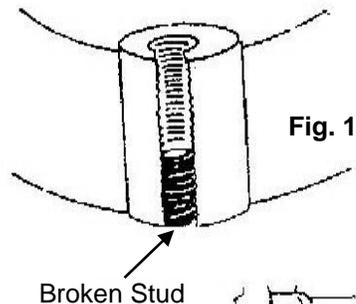


Fig. 1

Broken Stud

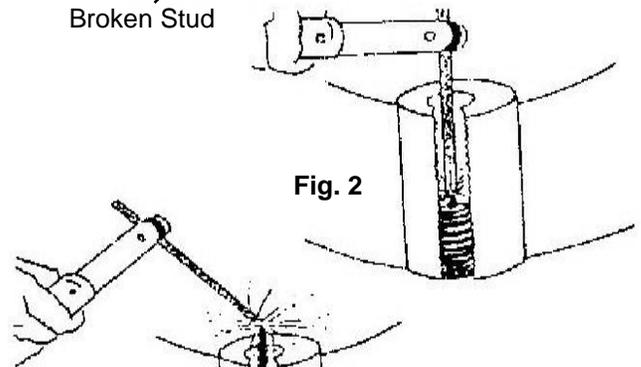


Fig. 2

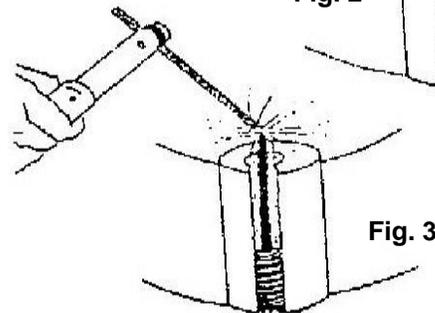


Fig. 3

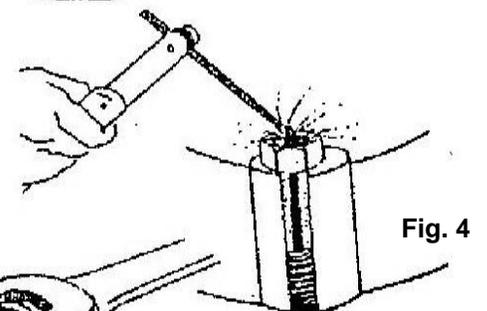


Fig. 4

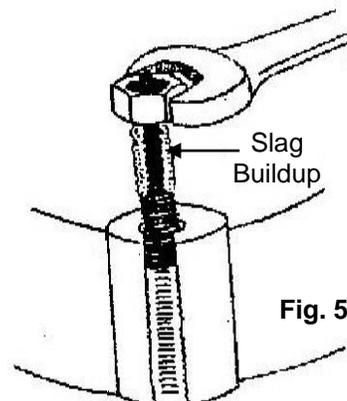


Fig. 5

Slag  
Buildup