



SUPER STRENGTH ELECTRODE FOR WELDING HIGH ALLOY STEELS

AC or DC REVERSE (ELECTRODE+)

GENERAL CHARACTERISTICS:

A low heat input electrode designed to produce the highest tensile welds. It can be used in all positions to produce smooth, porosity free welds without undercut or spatter.

APPLICATIONS:

Welding low, medium and high alloy steels requiring the highest strength and quality. Ideal for repair of tools, dies, springs, carbon steels, stainless steels, pressure vessels, aircraft steels, vanadium-moly spring steels and as an underlayment or pad prior to applying hard facing alloys. Commonly used for joining stainless of unknown analysis and these steels to carbon steels. Also used for rebuilding shafts and blades used in the chemical, construction and mining industries.

TECHNICAL DATA:

Tensile Strength as welded	up to 120,000 psi (82 kg/mm ²)			
Work hardens	up to 180,000 psi (126 kg/mm ²)			
Yield Strength	up to 90,000 psi (63 kg/mm ²)			
Elongation %	approx. 28			
Hardness (HB)	approx. 300			
Current	AC or DC reverse polarity (electrode+)			
Amperage	40-80	65-120	90-150	140-220
(in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

PROCEDURE:

Prepare joint area by removing foreign material. Bevel heavy sections to form a 90° vee. Preheat high carbon steels to 400° F (204°C). Use jigs, fixtures and tack welds to maintain alignment. Hold a short arc. Stringer beads are preferred to prevent overheating. Allow to cool before removing slag. Deposits will take a high polish when subjected to wear.

Manufactured by **AmAlloy Industries®**
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