

SUPERTRODE

PREMIUM HIGH STRENGTH ELECTRODE FOR WELDING LOW CARBON STEELS

AC OR DC EITHER POLARITY

GENERAL CHARACTERISTICS:

This electrode features the ease of welding of a mild steel electrode with the tensile strength of a low hydrogen electrode. Welds in all positions, excellent strike and restrike. Slag is usually self releasing. Weld on thin sheets without burn through. Designed to take the place of 6011, 6013, 7014 or 7018. Supertrode features an extremely wide amperage range.

APPLICATIONS:

Use for fabrication of thin, medium and heavy sections of mild steels. Useful for build up of worn or incorrectly machined parts. Excellent restrike characteristics make this an ideal electrode for short intermittent or tack welds. Use to weld machine parts, pipe, plates, angle and sheet in all positions.

TECHNICAL DATA:

Tensile Strength.....	up to 85,000 psi (580 N/mm ²)			
Yield Strength	up to 78,300 psi (540 N/mm ²)			
Elongation	approx. 28%			
Current	AC or DC Either Polarity			
Amperage	25-80	40-120	70-160	120-210
(in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

PROCEDURE:

As much foreign material as practical should be removed from the weld area. Deep Penetration can be accomplished by using DC reverse polarity (electrode +) Limited penetration and a flatter bead will result from using DC straight polarity (electrode -). Arc blow can be prevented by using AC. Maintain medium arc length with either stringer or weave beads. Slag can be easily removed with a light chipping hammer.

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EASY WELD SUPERTRODE