



125 BLACKSTONE AVE.

JAMESTOWN, NY
1-800-356-WELD

747 ULTRA

THE ULTIMATE ELECTRODE FOR WELDING ALL TYPES OF STEELS, WITHOUT ANY DANGER OF CRACKING OR BREAKAGE

GENERAL CHARACTERISTICS:

Because maintenance shops often have old or inexpensive welding equipment, New and Improved 747 ULTRA has been reformulated to provide the best possible arc stability, even under adverse conditions. It is amazingly stable on low open circuit voltage, AC buzz boxes. The weld metal transfer is especially smooth and there is almost no spatter. Arc restrike is instantaneous. "Insta Peel"™ makes the slag virtually self-releasing. It is without doubt the best possible product to use on unknown steels and dissimilar metal combinations.

APPLICATIONS:

Due to its exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel, and any dissimilar metal combinations, with the exception of the aluminums and copper alloys. Because the weld metal is so tough, it is also recommended for repairing worn parts, and also as an underlayment for hard facing. Because of its low amperage requirements and exceptional ease of use, it should be the first choice for both home hobbyists and maintenance welders for tough or unknown weld metal applications.

TECHNICAL DATA:

Tensile Strength as welded	up to 127,000 psi (882 N/mm ²)			
Yield Strength	up to 90,000 psi (620 N/mm ²)			
Elongation %	approx. 37			
Hardness (HB)	approx. 320			
Current	AC or DC reverse polarity (electrode+)			
(especially recommended for AC)				
Amperage	35-70	70-120	75-140	130-200
(in)	3/32"	1/8"	5/32"	3/16"
(mm)	2.5	3.25	4.0	5.0

PROCEDURE:

The area in which the weld is to be made should be free of rust, grease, paint, and other materials which cause weld contamination. A 90° vee joint should be used when joining heavy sections. Preheat is necessary only for high carbon steels, which should be preheated to 350°F (176°C), the interpass temperature should be kept below 500°F (260°C). Alignment should be maintained by the use of fixtures, tack welds, or other types of mechanical support. Maintain a short arc length and use stringer beads. Avoid weaving whenever possible.

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ALL STEEL ALLOY 747 ULTRA