

# 889 MAXX

## **VERY HIGH STRENGTH LOW ALLOY ELECTRODE FOR WELDING OF LOW TO MEDIUM CARBON AND LOW ALLOYED STEELS**

**AC OR DC REVERSE (ELECTRODE+)**

### **GENERAL CHARACTERISTICS:**

All position, low hydrogen iron powder type electrode with a fast and efficient metal transfer. Deposits have outstanding elongation and ductility and provide crack-free welds under highly stressed conditions. The slag is easily removed from the smooth welds which are easily machined.

### **APPLICATIONS:**

889MAXX is designed to weld low alloy high strength steels such as T-1, Hy-80, Hy-90, Hy-100, SSS 100 and Jalloxy 90 and 100. Commonly used to fabricate tanks, containers, covers and high strength pipe. Also recommended for welding low alloy steels containing nickel, manganese, molybdenum, and chromium such as I-beams, angle iron, scaffolding, and super-structures. Weldments can be used "as welded" or "stress relieved".

### **TECHNICAL DATA:**

Tensile Strength.....	up to 130,000 psi (779 N/mm <sub>2</sub> )			
Yield Strength .....	up to 104,000 psi (717 N/mm <sub>2</sub> )			
Elongation (in 2 inches) .....	approx. 25%			
Current .....	AC or DC reverse polarity (electrode+)			
Amperage	70-120	100-150	120-210	200-275
(in) 3/32"	1/8"	5/32"	3/16"	
(mm) 2.5	3.25	4.0	5.0	

### **PROCEDURE:**

No preheat is necessary when welding low carbon steels. When joining heavy sections to thin sections and when low alloy or higher carbon steels are welded, a preheat of 400°F to 600°F (200°-300°C) is recommended. Maintain a short arc with either stringer or weave beads. Allow deposit to cool normally before chipping off slag. To stress relieve, heat to 1025°F (550°C) and maintain for 1 hour.