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**E/0 8600**

**DATA SHEET**

GENERAL CHARACTERISTICS:

All position AC/DC coated electrode, depositing high alloy weld metal, designed to produce crack-free deposits having very high mechanical properties. Specially formulated high-alloy electrode for welding dissimilar, unknown, and problem steels. Superior performance of limited input AC welding machines. Highly alloyed special manual electrode for joining a broad range of difficult to weld metals including austenitic-manganese, air-hardening and high-carbon steels, and for joining dissimilar joining.

APPLICATIONS:

* **GOOD FOR ALL ALLOY & CARBON STEELS** - low-medium-high in all positions, under all conditions, including dissimilar combinations.
* Weld all tool steels, manganese steels and specialty steels in thick-to-thin designs.
* Will deposit using non-commercial AC or DC power sources having very low open circuit voltage characteristics.
* Drag or touch welding technique may be used, particularly in fillets without slag interference.

A diagram of a weld

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* **Tensile/Yield Strength:** 120K / 79K PSI
* **Hardness:** 90 HRB
* **Current Polarity:** DCEP (+) AC (-)
* **Electrode Size: Amperage:**

1/16” 25-55

3/32” 55-70

1/8” 75-95

5/32” 90-115

3/16” 135-190

PROCEDURE:

Clean surface and deposit electrode maintaining short to medium arc length. Tilt electrode 15° in direction of travel. For rapid filleting, raise amperage slightly and drag weld, inclining the electrode 45° in the direction of travel. Back-whip craters and remove slag between passes. **Note: For max. strength, use straight stringer beads, chip slag between passes.**