



Overview

One of the truly amazing products of modern metal technology. This ultra-versatile alloy quickly and easily produces a strong hard weld that can be machined and polished to a mirrorlike finish. Welds most types of ferrous and non-ferrous metals or joins any combination of dissimilar metals, except white metals.

Features/Benefits

- High strength factor
- High frictional wear resistance
- All-position welding ease
- Safe, solid weld on most ferrous, non-ferrous and dissimilar metals in all combinations
- Tough, crack-free, easily machinable welds
- Easy arc control – little or no preheating required

Applications

- Tool steels and dies
- Bronze to cast iron
- Brass to steel
- Gear teeth, turbines and impellers
- Cast iron to steel
- Aluminum bronze castings
- Gate valves and valve seats
- Cams and shafts

Method of Application

DC reverse polarity

Identification

Printed electrode, gray coating

Directions for Use

Use DC reverse polarity. Clean surfaces of grease, rust or scale. Use short arc with weave or stringer bead. No preheating required except on heavy sections; 500°F (260°C) steel, 900°F (480°C) copper.

Technical Specifications

Tensile Strength: 110,000 PSI (758 MPa)

Hardness: Rc 21 to Rc 23

Technical Tips

On cast iron, steel, Monel® or bronze, where a wear factor exists, 625 Electrode provides a buildup of surfacing deposit that will outwear steel, 3-to-1.

