

T H E H A R R I S P R O D U C T S G R O U P A L I N C O L N E L E C T R I C C O M P A N Y 4501 Quality Place • Mason, OH 45040 U.S.A Tel: 513-754-2000 Fax: 513-754-6015

TECHNICAL SPECIFICATION SHEET

ULTRA SUPER MISSILEWELD COVERED ELECTRODE

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

TYPICAL MECHANICAL PROPERTIES AS WELDED:

Tensile Strength (psi) Up to 128,000 psi Elongation % in 2" Up to 32% Yield Strength (psi) Up to 90,000 psi Hardness 200-300 Brinell

WELDING PROPERTIES:

This alloy has ultimate features which has the ability to weld over its own flux making it an exceptional stud removal electrode. The nominal composition of this weld metals assures exceptional strength with crack resistance welds on problem steels such as high carbon, tool steels, stainless steels, spring steels, dies and dissimilar steels.

WELDING PROCEDURE:

Use AC or DC reverse polarity bevel heavy sections if the base metal is high carbon steel a 400f preheat would be recommended hold a tight arc and run a stringer bead. Penning will help relieve stresses let each pass cool and slag will peel off easily.

*RECOMMENDED WELDING PARAMETERS:

	3/32x9	1/8x14	5/32x14	3/16x14
AMPS	40-80	70-110	95-145	145-200

^{*} All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors. SPECIFICATION COMPLIANCE: INTERNAL

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, Safety in Welding, Cutting, and Allied Processes, published by the American Welding Society, 550
 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

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