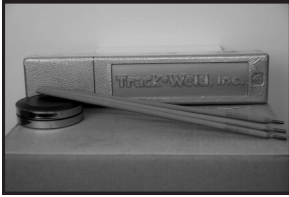


## TRACK-WELD 900 Flux-Coated Stick Electrode



TRACK-WELD 900 Flux-Coated Electrode is high strength electrode designed to be used to join and fill deep cracks in manganese castings. The

deep penetrating characteristics allow it to tie in and fill casting defects and sand pockets. It is also used as an underlayment for the FROGBUILD products. TRACK-WELD 900 should be kept 3/4" or more below the running surface.

### PROCEDURES:

Remove all cracks by grinding or air carbon arc gouging. Defect area must be prepared to ensure there is room to weave the electrode for 100% penetration and complete tie in to the base metal. Maintain approximately a 30-degree angle on the electrode and hold a short arc.

### TECHNICAL DATA:

DC Reverse Polarity	
Tensile Strength (as welded) .....	120,000 PSI
Tensile Strength (work hardened) .....	180,000 PSI
Yield Strength .....	90,000 PSI
Elongation .....	40%
Hardness.....	100 Rc

### WELDING PARAMETERS:

1/8"	110-130 Amps
5/32"	140-160 Amps
3/16"	170-200 Amps

### ORDERING INFORMATION:

900-3 .....	1/8" Dia, 40lb Box
900-4 .....	5/32" Dia, 40lb Box
900-5 .....	3/16" Dia, 40lb Box