

Technical Data Sheet

3330 Electrode The Ultimate All-Steel Alloy



Cronatron™
A LAWSON BRAND



Overview

3330 Electrode is a high-strength, high-elongation alloy that utilizes a revolutionary engineering balance and concept in electrode design. The unique operating characteristics of 3330 Electrode produce the ultimate in tough, crack-resistant deposits on all types of steel.

Features/Benefits

- Lowest amperage settings allowable with special alloy steels
- First in out-of-position quality
- Super-smooth deposits – even on small “buzz box” machines
- No annoying or hazardous fumes from painted coatings
- Fast-freeze deposition in all positions
- Self-timing precision removing slag
- Non-cracking deposits on all types of steel and dissimilar steels

Applications

- Broken bolt removal*
- Manganese steel to carbon steel
- Mining equipment
- Tools and dies
- Rails
- Axles
- Banjo housings
- Sprockets
- Dissimilar steels

Method of Application

AC or DC reverse polarity

Identification

Printed red electrode

Directions for Use

Use AC or DC reverse polarity. Electrode may be used in a contact “drag” fashion, or by holding a short arc. Stringer beads or a slight weave is best. Remove slag between passes. When welding alloy or tool steel preheat according to base-metal requirements. For vertical-up welding use a 1/8" electrode at approximately 65A to 70A, or a 5/32" electrode at 75A to 85A. Use a weave “ledge” technique, pausing momentarily at end of weaves.

Technical Specifications

Tensile Strength: 127,000 PSI (876 MPa)
Elongation: 37%
Hardness: 235 BHN

*For detailed instructions see Product Information Report PIRWE011.
For Stud Stretcher kit order No. CW3030.

