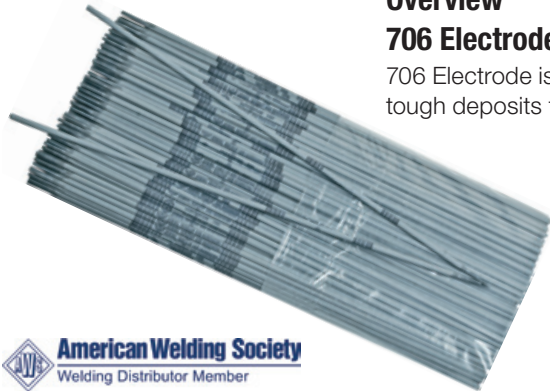




Overview

706 Electrode

706 Electrode is a high-efficiency electrode, maintenance-engineered to provide extremely tough deposits for buildup on all types of steel, including manganese and stainless steel.



Features/Benefits

- Versatile and easy to use on all steels
- Controlled ferrite to resist cracking
- Work-hardens rapidly with a minimum of deformation
- Deposition rates 20% to 25% greater than ordinary electrodes
- High efficiency yields more weld metal per electrode
- Maintains strength and hardness to 1,000°F (540°C)
- Excellent buildup alloy for hardfacing

Applications

- Buckets
- Loaders
- Swing hammers
- Chain links
- Rails
- Wearplates
- Frogs/switch points
- Furnace linings
- Crusher mantles
- Crusher jaws
- Low alloy – also quenched and tempered steels
- Boiler baffles – firebox
- Sheets – kiln lining
- Furnace – boiler castings
- Jigs, fixtures and molds
- Foundry racks and frames
- Augers, impellers and rams
- Stainless valves and pumps
- Grouser bars
- Buildup and underlay prior to application of hardsurfacing or tool and die electrodes

Method of Application

AC or DC reverse polarity

Identification

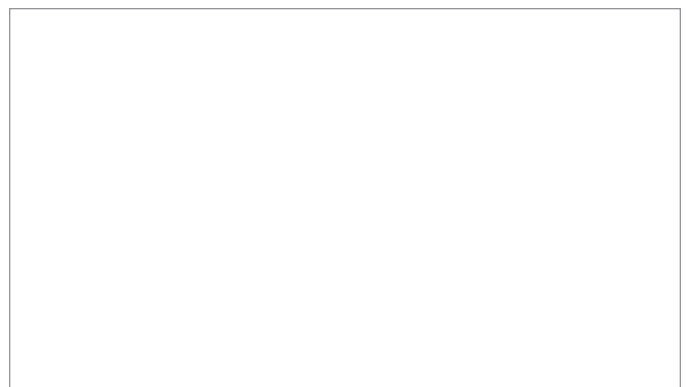
Printed electrode, gray coating

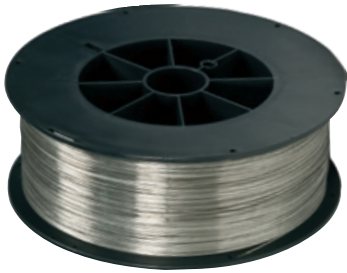
Directions for Use

Use AC or DC reverse polarity. Electrode may be used in contact or by holding an arc. When used for joining, stringer beads are best. When used as a buildup, weaving is acceptable. Manganese steel should be kept below 550°F (290°C) by skip welding or artificial cooling. Prior to buildup, all fatigued, cracked or spalled material should be removed. Chip slag between passes.

Technical Specifications

Tensile Strength: 101,000 PSI (696 MPa)
 Elongation: 34%, as deposited
 Hardness: Rc 45, work hardened





Overview
706FC MIG Wire



Features/Benefits

- High deposition, flux-cored wire for heavy build-up
- Can be used on all weldable steels
- Rapid work-hardening
- Maintains strength and hardness up to 1,000°F (540°C)

Applications

- Buckets
- Loaders
- Hammers
- Chains
- Wearplates
- Frogs and switch points
- Jaws and crusher mantles
- Grouser bars
- Build-up for hardfacing

Method of Application

MIG welding machine, DC reverse polarity

Identification

Labeled spool

Directions for Use

Remove all cracked or spalled material before welding. Run on DC reverse polarity. No shielding gas needed. Use stringer or weave beads. Chip slag between passes.

Technical Specifications

Tensile Strength: 95,000 PSI (655 MPa)
 Yield Strength: 73,000 PSI (503 MPa)
 Elongation: 38%
 Hardness: Rc 45, work hardened
 Shielding Gas: None