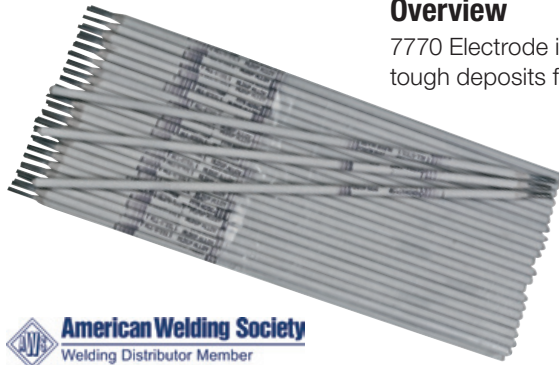


Technical Data Sheet

7770 Electrode The Heavy-Duty Alloy



Cronatron™
A LAWSON BRAND



American Welding Society
Welding Distributor Member

Overview

7770 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
- All-position welding characteristics
- 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

Applications

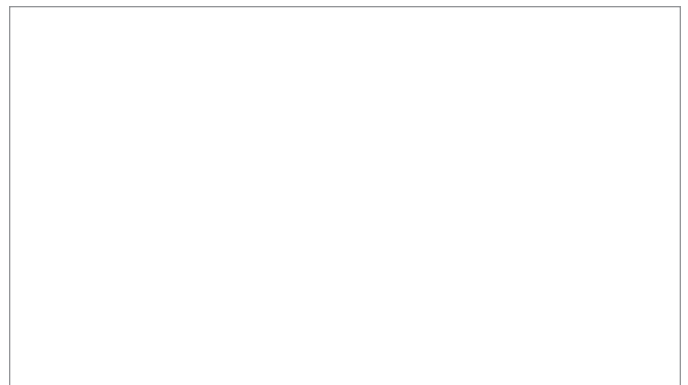
- Buildup and sandwich technique alloy for coal sizing hammers
- Buildup of manganese or carbon steel prior to overlaying with more abrasion-resistant material
- Welding alloy steel cutting edges or lips to manganese buckets
- Shaft buildup
- Repairing crusher rolls and jaws
- Repairing gears, spiders, booms, rails, chain links and valves

Method of Application

AC or DC reverse polarity

Identification

Printed gray electrode



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 away slag between passes.

Technical Specifications

Compressive Strength: To 250,000 PSI (1,724 MPa)
Hardness: RC 45, Work hardened
Elongation: 35%

Technical Tips

Because of the high-efficiency design of 7770 Electrode, each diameter deposits the amount of weld metal that would normally be deposited with an electrode one size larger.
For 7770M-FC MIG Wire typical operating parameters refer to Product Information Report PIRWE010.