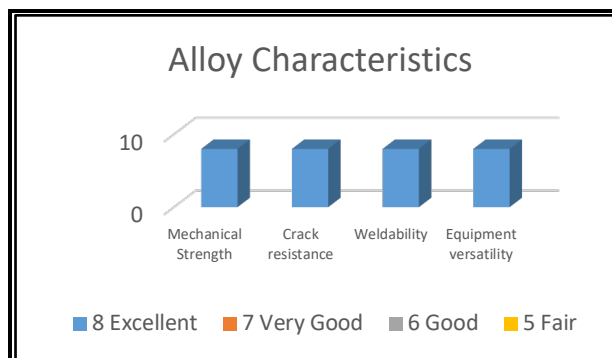


EXCEL BOND 086 S



TYPICAL APPLICATION

All – position, contact type low heat input electrode, Suited for Dies, tools, springs, cushion layer, Joining dissimilar & unknown steel & stainless-steel combinations. Machinable build-up and overlay. Can be used to repair steel dies on the line without preheating. It works wonders on oily, greasy & contaminated surfaces without any defect.

PRODUCT FEATURES

1. Ultimate strength, austenitic-ferritic balance electrode.
2. Versatile electrode for all steels, contact type with self-lifting slag.
3. Deposits are tough with very high crack resistance.
4. Welds in all positions & low operating current avoids distortion.

RECOMMENDATIONS

Frigid arc coating plus high-alloy core generates highly ionized arc. Outstanding strength & weldability. Excel Bond 068 produces high quality grain structure of similar & dissimilar steels and joining steels of different thickness. Excel Bond 066 can be used as buffer layer to make the repair economical & reliable.

PROCEDURE

Use AC or DC reverse polarity. Clean welding area. Bevel heavy sections. Tilt electrode 10-15° in direction of travel. The burn-off rate is rapid & uniform permitting rapid advance with no “sticking” or “drifting”. Restrict weaving to 2-3X electrode diameter. Peen to relieve stresses. Slag releases easily.

RECOMMENDED AMPERAGES

SIZE (mm)	AMPERAGE
5.00	195 - 235
4.00	120 – 145
3.15	100 – 120
2.5	70 – 85

TECHNICAL DATA

1. Current: AC/DC +

2. Tensile strength: 1, 20,000 psi

Mfd. By EXCEL CRAFT PVT. LTD. (WELDING DIVISION)

Plot No. 148 A, PLOT 1, 4th Phase, 7th Main Road, Bommasandra Industrial Area, Bangalore-560099

Web Site: www.excelcraft.net

E-mail: info@excelcraft.net