



TECHNICAL INFORMATION SHEET

SUPER MISSILEWELD® WELDING ELECTRODE

TYPICAL AS WELDED MECHANICAL PROPERTIES

Tensile Strength: Up to 120,000 PSI
Yield Strength: Up to 85,000 PSI
Elongation: 22% minimum

PROPERTIES:

The nominal composition of this weld metal assures dense, non-cracking welds on problem steels such as high carbon, tool steels, stainless steels, spring steels, manganese steels and dissimilar steels, or where steel composition is unknown. This alloy has excellent impact and frictional resistance and mild abrasion resistance.

GENERAL WELDING PROCEDURE:

Use AC or DC reverse polarity. Clean weld area. Bevel heavy sections. With high carbon steel a 400°F preheat is recommended. Hold a short arc and run stringer beads. Penning will help relieve stresses. Let each pass cool and slag will peel off easily. Applications should be limited to service temperatures below 800°F or parts should be tested to ensure suitability.

More detailed welding procedures should be developed for specific base metals and to confirm strength/corrosion requirements and weld mechanical properties.

SUGGESTED WELD SETTINGS:

3/32 (2.4 MM) X 9 (225 MM)	1/8 (3.2 MM) X 14 (350MM)	5/32 (4.0 MM) X 14 (350MM)	3/16 (4.8 MM) X 14 (350 MM)
40 – 80 AMPS	70 –110 AMPS	95 – 145 AMPS	145 – 200 AMPS

SPECIFICATION COMPLIANCE:

Harris Products Group internal welding products specification.

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

ARC RAYS can injure eyes and burn skin.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

ELECTRIC SHOCK can kill.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

WARNING: This product contains or produces a chemical known to the State of California to cause cancer and birth defects, (or other reproductive harm).

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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Additional information is available at our web site: www.harrisproductsgroup.com