



All Position
Carbon Steel Electrode

BeautyWeld® II



- High quality deposits with minimal spatter
- Welder friendly
- Smooth slag release for fast and easy clean-up
- Excellent re-strike characteristics increase productivity

BeautyWeld II

Beautyweld II is a low-carbon electrode for general maintenance and repair with excellent performance and results. High quality, smooth profiled beads are easily attained with minimal spatter, for fast and easy clean-up. Reliable properties and excellent re-strike characteristics make Beautyweld II a popular and easy choice for spot and intermittent welding or any other carbon, plain and low-alloy steel applications.

TECHNICAL DATA

Typical Values

Tensile Strength:	80,000 psi (552MPa)
Yield Strength:	68,000 psi (469 MPa)
Elongation (1=5d) min.:	approx. 24%
Hardness as-deposited:	95 HRB
Current polarity:	AC/DCEP (+)

A Range Thick Sections, heavy build-up (multi-pass)

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	140-180	180-250

B Range Moderate Sections

DIAMETER	1/16" (1.6mm)	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	20-50	35-80	90-130	120-160

PROCEDURE FOR USE

PREPARATION: Clean weld area. Remove all damaged and fatigued metal, cracks and sharp corners. (Xuper Exotrode® is recommended).

TECHNIQUE: When joining, bevel heavy sections. Preheat is unnecessary unless heavy sections or crack-sensitive base metals are involved.

Use AC/DCEP (+) with "A" range for highest deposition rate. Maintain medium arc. Tilt electrode in direction of travel. Weaving should be limited to 1 1/2"x the electrode diameter. Back whip and fill craters.

TYPICAL APPLICATIONS

BUILD-UP OR CLADDING APPLICATIONS:

Augers, Impactors, Buckets, Pump Casings, Bucket Teeth, Scraper Blades, Crusher Rollers & Jaws, Sprockets, Gear Teeth, Trencher Teeth, Hammers and Undercarriage Components

GENERAL APPLICATIONS:

Bucket Lips & Sides, Conveyor Buckets, Ripper Shanks, Dozer Cutting Edges, Screw Conveyor Flights, Loader Scoops, and Wheel Flanges

