All Position, Carbon Steel Electrode

BeautyWeld II

WELDING

• High quality deposits with minimal spatter
• Very Welder-friendly
• Smooth Slag release for fast and easy clean-up
• Excellent re-strike characteristics increase productivity and efficiency
DESCRIPTION:
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 and thus clean-up. Fast cleaning, reliable properties and excellent re-strike characteristics make Beautyweld a popular and easy choice for spot and intermittent welding or any other carbon, plain and low-alloy steel applications.

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, Undercarriage Components

GENERAL APPLICATIONS:
Bucket Lips & Sides, Manganese Filler bars, Conveyor Buckets, Ripper Shanks, Dozer Cutting Edges, Screw Conveyor Flights, Loader Scoops, Wheel Flanges

TECHNICAL DATA:
Current: AC/DCEP (+)
Typical Tensile Strength: 80,000 psi (552MPa)
Typical Yield Strength: 68,000 psi (469 MPa)
Elongation: approx. 24%
Typical Hardness: Rb 95 as deposited
Rc 30 work hardened

PARAMETERS
A Range Thick sections, heavy build-up (multi-pass)
Diameters: 1/8  5/32
Amperage:  140-180  180-250

B Range Moderate sections
Diameters: 1/8  5/32
Amperage:  90-130  120-160

WELDING PARAMETERS:
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.

DO NOT HEAT 14% MANGANESE STEEL OVER 400°F.

HEALTH AND SAFETY:
Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 “Safety in Welding and Cutting and Allied Process”. Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s).

Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information.

DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.