

All Position, Carbon Steel Electrode

Beauty Weld® 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: 1/16 3/32 1/8 5/32
Amperage: 20-50 35-80 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.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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