

A High Deposition Electrode for Rapid Welding of Mild and Low-Alloy Steels

EutecTrode® 777



WELDING

- Dense, porosity-free deposits
- More weld metal deposited per electrode than electrodes
- Ease of use leads to greater productivity
- Fast and Easy Cleaning



DESCRIPTION:

Eutectrode 777 is especially suited for high productivity welding in the flat, fillet and horizontal positions. Contact welding makes it easy to maintain optimum bead profile. Slag is generally self-releasing and weld deposits are smooth and regular.

TYPICAL APPLICATIONS:

For structural steel fabrications involving H-beams, thick cross-sectional angle-bars and flat-stock steel of various thickness e.g. machine frames, truck frames & bodies, earthmoving equipment fabrications, cast steel engine blocks, water tanks, steel housings, etc.

TECHNICAL DATA:

Typical Tensile Strength: 78,000 psi (538 N/mm²)

Typical Yield Strength: 69,000 psi (476 N/mm²)

Typical Elongation: (1=5d) min. 22%

Current & Polarity: DCEP (+) and AC

Availability and Recommended Amperages

Dia.	3/32" 2.4mm	1/8" 3.2mm	5/32" 4.0mm
Amp.	80-110	130-170	180-230

Note: Always keep electrodes in their container during storage. Damp electrodes can cause cracking & porosity. For re-drying procedures consult Eutectic Technical Services for more information on specific applications and alloys.

WELDING PARAMETERS:

Preparation: Clean weld area of scale and/or oxide. Bevel or chamfer heavy sections to have either a single or double 60° "V" prep. A nominal preheat of 150° F is advised if part is below 40° F or over 1" thick. For higher carbon steels higher preheats will be needed. Check the Reference Section for information regarding specific preheating levels for specific steel grades.

Technique: A "contact technique" is recommended for fillet welding and a reasonably small arc-gap for flat, bead-on-plate welding. Deposit stringer beads or 2x to 3x weave beads. Do not weave more than three times the electrode diameter otherwise slag interference will be encountered.

Post-Welding: Allow parts to slow cool in still air. High carbon steels should covered with a heat-retardant blanket.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



EUTECTIC CORPORATION
N94 W14355 Garwin Mace Drive
Menomonee Falls, WI 53051 USA
Tel.: +1 (800) 558-8524
eutectic.com

EUTECTIC CANADA
428, rue Aimé-Vincent
Vaudreuil-Dorion, Québec
J7V 5V5 Canada
Tel.: +1 (800) 361-9439
eutectic.ca

