

Superior Impact, Strength and Crack Resistance on Carbon Steels

EutecTrode® 966



WELDING

- All position welding electrode
- Easy-to-use, easy slag removal, versatile electrode
- Non-sulfur bearing striker tip for instant starts
- Good re-striking characteristics
- Moisture guard coating with non-conductive flux coating
- High strength combined with high elongation



DESCRIPTION:

EutecTrode 966 is a high quality electrode for low alloy, medium carbon and high tensile steels. Featuring rapid start, smooth arc control and easy slag removal. EutecTrode 966 was developed for joining and build-up on carbon steels, dirty steels, alloy steels, free machining steels and “problem” steels without cracking or porosity. It provides excellent physical properties and is recommended where high strength, machinable, ductile, dense, crack-free and porosity-free welds are of paramount importance.

TECHNICAL DATA:

Tensile Strength: 86,000 psi (595 N/mm²)
Yield Strength: 75,000 psi (520 N/mm²)
Elongation (1=5d): 36%
Polarity: AC/DC (+) All Position

Recommended Amperages

Diameter:	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
Amperage:	60-100	110-150	140-200
Part No.:	966-24-5K	966-32-5K	966-40-5K

Expected Charpy V-notch impact properties (as welded).

Temp.	72°F (22°C)	0°F (-18°C)	-20°F (-29°C)	-40°F (-40°C)
Ft. Lbs.	110	100	90	60
Joules	149	136	122	81

WELDING PARAMETERS:

Preparation: The area to be welded should be free of surface contamination such as rust, scale, grease or fatigued metal. Preheat heavy section or hardenable grades of steel to 400° F (200°C). Use carbon equivalency on steel to establish recommended preheats.

Technique: For highest X-Ray quality welds, maintain a short arc gap and chip slag between passes. On vertical welds, start at the bottom and weave slightly, pausing at the edges. For root passes, at a minimum gap (3/32" for 1/8" electrodes) and run stringer beads. For fill and cover passes a weaving technique is best employed.

Post-welding: Allow parts to slow cool in still air.

TYPICAL APPLICATIONS:

General fabrication and maintenance of structural work, construction and earthmoving equipment, mining and quarry machinery repairs, truck and trailer frames, material handling equipment, farm implements and rail equipment.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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