A Premium, Welder-friendly Low Hydrogen Electrode with Improved Mechanical Properties

EutecTrode® 9708QS

WELDING

- Excellent for most crack sensitive steels
- Improved Impact properties over other Low-Hydrogen Electrodes
- Innovative 'Quick Start' tip makes striking an arc fast and clean, every time

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

EutecTrode 9708QS is a “quick-start” electrode for porous-free arc starting on plain carbon and low-to-medium carbon steels.

Because of its improved impact properties and resultant increase in crack resistance, it can readily substitute for bulk low-hydrogen electrodes. Meets the AWS Specification A5.1 under class. E7018-1.

TYPICAL APPLICATIONS:

Use when welding constructional steels where improved crack-resistance is important. Fabrication & repair shops undertaking tank building, welding low-to-medium carbon steels used in earthmoving equipment, farming implements, steel-mill ore cars.

TECHNICAL DATA:

Typical Tensile Strength: 81,000 psi (558 N/mm²)
Typical Yield Strength: 72,000 psi (496 N/mm²)
Typical Elongation: (1=5d) min. 25%
Typical Impact Str.: Min. Charpy V-notch @-40°F: 20 ft-lb
Current & Polarity: DCEP (+) and AC

Availability and Recommended Amperages

Dia.	3/32“ 2.4mm	1/8“ 3.2mm	5/32“ 4.0mm
Amp.	60-100	100-145	140-200

Note: Always keep electrodes in their container during storage. Damp electrodes can cause cracking & porosity. For re-drying procedures check with Technical Services.

WELDING PARAMETERS:

Preparation: Clean weld area of scale and/or oxide. Bevel or chamfer heavy sections to have either a single or double 60º “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. Preheat as appropriate for the base metal chemistry and joint geometry.

Technique: All low-hydrogen electrodes should be used with a non-contact, short arcgap technique. Deposit stringer beads or 2x to 3x weave beads. Back whip craters to reduce crater cracking tendencies. When de-slagging make sure to thoroughly remove slag at the weld deposit toes.

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

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