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

Eutectrode® 9708QS

• 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®
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

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<tr>
<th>Dia.</th>
<th>3/32&quot; 2.4mm</th>
<th>1/8&quot; 3.2mm</th>
<th>5/32&quot; 4.0mm</th>
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<tr>
<td>Amp.</td>
<td>60-100</td>
<td>100-145</td>
<td>140-200</td>
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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 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. 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.