



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

EutecTrode® 777



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

EutecTrode® 777

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

TECHNICAL DATA

Typical Values	
Tensile Strength:	78,000 psi (538 N/mm ²)
Yield Strength:	69,000 psi (476 N/mm ²)
Elongation (1=5d):	min. 22%
Current & Polarity:	DCEP (+) and AC

SUGGESTED WELDING PARAMETERS:

Diameter	Amperage
3/32" (2.4mm)	80 - 110
1/8" (3.2mm)	130 - 170
5/32" (4.0mm)	180 - 230

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

PROCEDURE FOR USE

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.

TYPICAL APPLICATIONS

For structural steel fabrications involving H-beams, thick cross-sectional angle-bars, and flat-stock steel of various thickness. Examples include, but are not limited to, machine frames, truck frames and truck bodies, earthmoving equipment, fabrications, cast steel engine blocks, water tanks, steel housings, etc.

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



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