



Superior Impact Strength and
Crack Resistance on Carbon Steels

EutecTrode® 966



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

EutecTrode® 966

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

Typical Values	
Tensile Strength:	86,000 psi (595 N/mm ²)
Tensile Strength:	75,000 psi (520 N/mm ²)
Elongation (1=5d):	36%
Polarity:	AC/DC (+) All Position

SUGGESTED WELDING PARAMETERS:

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

EXPECTED CHARPY V-NOTCH IMPACT PROPERTIES (as welded):

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

PROCEDURE FOR USE

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, truck and trailer frames, material handling equipment, farm implements and rail equipment.

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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