



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

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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.

TECHNICAL DATA

Typical Values

Tensile Strength:	81,000 psi (558 N/mm ²)
Yield Strength:	72,000 psi (496 N/mm ²)
Elongation (1=5d):	Min. 25%
Impact Strength (Charpy V):	20 ft - lbs at -40°F
Current & Polarity:	DCEP (+) and AC

SUGGESTED WELDING PARAMETERS:

Diameter	Amperage
3/32" (2.4mm)	60 - 100
1/8" (3.2mm)	100 - 145
5/32" (4.0mm)	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.

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 (65°C) is advised if part is below 40°F (4°C) 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 arc gap 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.

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 and steel-mill ore cars.

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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