



Premium, High Strength Low  
Hydrogen Electrode with Advanced  
Impact Resistant Properties

# **EutecTrode®**

## **Super 110**



- For critically stressed applications
- Premium high strength, low hydrogen electrode
- Advanced impact properties
- Excellent for welding construction steels

# EutecTrode® Super 110

EutecTrode Super 110 is formulated for welding critically stressed fabrications where high impact properties are needed and where the weldment is under severe restraint.

Used with low-to-medium carbon steels and HSLA steels of similar strength.

## TECHNICAL DATA

### Typical Values

<b>Tensile Strength:</b>	110,000 psi 759 N/mm <sup>2</sup>
<b>Yield Strength:</b>	98,000 psi 676 N/mm <sup>2</sup>
<b>Impact Strength:</b>	Minimum Charpy V-notch @-60°F: 45-60 ft-lb
<b>Current &amp; polarity:</b>	DCEP (+) and AC

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
AMPERAGE	60-100	110-145	140-210

## 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 of the Eutectic Corporation Technical Data Book for information regarding specific preheating levels for specific steel grades.

**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 advanced crack-resistance is critically important.

- Tank building
- Earthmoving Equipment
- Construction Equipment
- Steel-Mill Ore Cars



**Eutectic Corporation:**  
N94 W14355 Garwin Mace Dr.  
Menomonee Falls WI, 53051 USA  
+1 800. 558. 8524 • eutectic.com

**Eutectic Canada:**  
428, rue Aimé-Vincent Vaudreuil-Dorion,  
Québec J7V 5V5 Canada  
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

