



General Purpose Electrode for Welding Low  
Carbon Steels in Any Position

# UltraMax 80



- Ultimate all-position weldability
- Exceptional strike / restrike (no sticking)
- Excellent for rapid repairs on both thin and thick-section metals

# UltraMax 80

UltraMax 80 has been designed to operate on almost any AC or DC welding machine even when the open circuit voltage is very low. The special coating protects the weld deposit from adverse conditions normally encountered in maintenance and repair welding. Low amperage requirement controls distortion when welding thin sheet metal; spatter is kept to a minimum. Ideal for field repair work and out-of-position welding.

## TECHNICAL DATA

Typical Values	
Tensile Strength:	Up to 80,000 psi (552 MPa)
Yield Strength:	Up to 68,000 psi (469 MPa)
Elongation:	Approx. 24%
Current & Polarity:	AC or DC (+/-)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	35-80	65-125	90-160

## PROCEDURE FOR USE

**PREPARATION:** Remove as much contamination as practical from weld area.

**TECHNIQUE:** DCEP (electrode+) produces deep penetration; DCEN (electrode-) will have limited penetration and a flatter bead. Use AC to prevent arc-blow. A medium arc length should be maintained with either stringer or weave beads. Slag is easily removed by lightly tapping with a chisel or chipping hammer.

*Note: Always keep electrodes in an appropriate dry storage container or rod oven once opened to prevent excess moisture absorption. Inappropriately stored electrodes can cause cracking and porosity in the weld. For additional information on exposure time, redrying and storage contact Technical Services.*

## TYPICAL APPLICATIONS

Fabrication of thin, medium, heavy and dissimilar gauge mild steels. Sheets, plates, angle iron, beams, pipes and machine parts can be welded in all positions.

Also used for filling holes and build-up of over-machined and worn surfaces. Commonly used on applications requiring short, intermittent and spot welds because of the outstanding restarting characteristics.



**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



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