

TECHNICAL DATA SHEET

 **Starweld 677**

AC / DC+

ALLOY STEEL

Description :

High strength electrode for welding alloy steels, carbon steels, unknown stainless steels, tempered steels, manganese steels, and difficult-to-weld steels requiring maximum elongation.

Characteristics :

- **Crack-resistant deposit**
- Excellent heat, corrosion and vibration resistance
- Excellent on AC power supply
- Low spatter and easy slag removal
- Very high elongation

Mechanical properties :

- Polarity AC / DC +
- Tensile strength : 100 000 psi (689 MPa)
- Limite d'élasticité : 68 000 psi (468 MPa)
- Elongation : 38 - 43 %
- Impact (Charpy V) : 60 J at +20°C

+ **Diamètre**
+ **Ampérage**

2.5 mm
70 A

3.2 mm
100 A

4.0 mm
120 A

5.0 mm
160 A

Applications :

Recommended for steels susceptible to cracking, difficult-to-weld steels, unknown stainless steels, tempered steels, manganese steels, truck frames, railroads, switches, chain links, gear teeth, etc. Excellent as a cushion before hardfacing on tool steel.

**Also available in FCAW flux-cored wire Starweld 2677 FFG
and in TIG Starweld T677**

1 800 361 9097

 **Starweld**