

TECHNICAL DATA SHEET

 **Starweld 685**

AC / DC +

ALLOY STEEL

Description :

Super strength electrode for welding of high alloy steels and all types of unknown steels together, or as dissimilar assemblies. Excellent as a cushion before hardfacing on high alloy steels.

Characteristics :

- **Exceptional mechanical properties and weldability**
- Machinable deposits
- Excellent cracking, corrosion, oxidation, heat, impact and wear resistance

Mechanical properties :

- Polarity AC / DC +
- Tensile strength : 132 000 psi (910 MPa)
- Yield strength : 75 000 psi (517 MPa)
- Elongation: up to 30 %
- Hardness (as welded) : 22 HRC
- Work-hardened: 52 HRC

Procedure :

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the Soudotec 212 SP or Soudotec G12 electrode. Maintain a short arc. Peens while still hot between each pass to stress relieve. Remove slag between each pass. For some high alloy steels, preheating is recommended.

| | | | |
|-------------------|--------|--------|--------|
| + Diameter | 2.5 mm | 3.2 mm | 4.0 mm |
| + Amperage | 60 A | 100 A | 125 A |

Applications :

Numerous applications involving the maintenance and repair of machine parts, tools, dies, springs, spring steel, as well as the rebuilding of shafts and blades.

1 800 361 9097

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