



SUPER 120

DESCRIPTION: Due to exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for the aluminum and copper alloys. It is also recommended for repairing worn parts and as an underlay for hardfacing.

PROCEDURE: Use either AC or DC reverse polarity (Electrode +). The area in which the weld is to be made should be free of rust, grease, paint and other materials which cause weld contamination. A 90° vee joint should be used when joining heavy sections. Maintain a short arc length and use stringer beads. For high carbon steels, a preheat of 400°F is recommended.

CHEMICAL COMPOSITION PROPRIETARY

MECHANICAL PROPERTIES

Tensile Strength	
132,300 PSI	910 MPA
Yield Strength	
94,000 PSI	660 MPA
Elongation	36%
Impact Energy	50J:68°F
Hardness	
Rockwell B-97	Brinell 320

WELDING POSITION: Flat, Horizontal, Vertical up, Overhead

Amperages:

3/32"	35-70
1/8"	60-110
5/32"	75-140
3/16"	130-200

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.