



EAGLE 827

Jet type electrode for welding low alloy steels.

APPLICATIONS

Welding of angles, channels, structural steels, mild steels, and for general maintenance.

PROCEDURE

AC or DC straight polarity (-). Clean weld areas with a grinder and groove out the cracks using the **EAGLE 188**. All welds should be welded in the flat and horizontal position. The electrode should be tilted in the direction of travel while maintaining contact with the base metal. Slag must be removed from the previous weld deposits.

GENERAL CHARACTERISTICS

The **EAGLE 827** has a smooth arc on both AC and DC. It produces very little spatter and the slag is very easy to remove.

TECHNICAL DATA

Tip Color:	Plain				
Tensile Strength: Psi	Approximate 70,000				
Elongation:	Approximate: 20 - 25%				
Current:	AC - DC Straight (-)				
Sizes: (IN)		3/32	1/8	5/32	3/16
(MM)		2.50	3.25	4.00	5.00
Amperage:		40 - 85	75 - 140	100 - 190	190 - 240

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