



EAGLE 866 Ultra Chrome

High strength alloy for dissimilar metals.

APPLICATIONS

For build-up and joining of all grades of low alloy steels, tool steels, high alloy steels and carbon steels. Can be used for rebuilding shafts, forging dies, hot shearing blades, dies, punches, conveyor chains and debarker knives.

PROCEDURE

AC or DC reverse polarity (+). Clean weld areas with a grinder. Preheat carbon steels to 400° F. Maintain a short arc and stringer beads are recommended to prevent overheating. Allow weld to cool before removing slag.

GENERAL CHARACTERISTICS

The **EAGLE 866 Ultra Chrome** is a ferritic austenitic electrode that has outstanding control in all positions. The transition zones and weld metal are fully machinable. Striking and re-striking qualities are excellent. The low heat quality allows for spatter free deposits in all positions.

TECHNICAL DATA

Color Tip:	Red						
Tensile Strength: Psi	Approx: 120,000						
Elongation:	Approx: 30 - 35%						
Current:	AC - DC Reverse (+)						
Sizes (IN)		1/16	5/64	3/32	1/8	5/32	3/16
(MM)		1.60	2.00	2.50	3.25	4.00	5.00
Amperage:		30 - 40	40 - 60	45 - 80	80 - 120	120 - 150	160 - 180

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