



EAGLE 878

Superior high strength alloy for joining hard to weld steels

APPLICATIONS

For joining and build-up on frog points, machinery parts, hot dies, and repair of manganese bucket lips, teeth to bucket shells and for shaft buildup. This electrode can be used for hardsurfacing of pipeline ditcher segments and for joining wear plates to carbon steel.

PROCEDURE

AC or DC reverse polarity (+). Clean weld areas with a grinder and groove out cracks using the **EAGLE 188**. Maintain a short arc length and use stringer beads.

GENERAL CHARACTERISTICS

The **EAGLE 878** has a moisture resistant coating which provides high strength porosity free welds. The slag is self-removing and this alloy can be welded in all positions.

TECHNICAL DATA

Tip Color:	Yellow			
Tensile Strength: Psi	Approximate 105,000			
Elongation:	Approximate 32%			
Hardness (RC)	Approximate 14			
Current:	AC – DC Reverse (+)			
Sizes: (IN)		3/32	1/8	5/32
(MM)		2.50	3.25	4.00
Amperage:		30 - 80	60 - 110	110 - 150

www.eaglealloys.ca