



# EAGLE 865

*High Strength Low Heat Electrode For Joining  
And Buildup Of Dissimilar Steels*

## APPLICATIONS

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

## PROCEDURE

Use 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 to cool before removing slag.

## GENERAL CHARACTERISTICS

The **EAGLE 865** has a low heat input with excellent welding properties. It is heat resistant, corrosion resistant and is designed to produce the high tensile strength welds needed in today's welding industry.

## TECHNICAL DATA

Tip Colour: Blue  
Tensile Strength: Approx. 120,000 psi  
Elongation: Approx. 30 - 35%

## WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity							
Sizes: Inches	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:	20 - 40	40 - 60	60 - 80	90 - 120	125 - 160	160 - 180		



≡ HIGH QUALITY WELDING PRODUCTS ≡

10077 - 166 STREET, EDMONTON, ALBERTA T5P 4Y1 • BUS: (780) 481-8082  
FOR TECHNICAL ASSISTANCE CALL US TOLL FREE 1-800-447-1415