



# 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. 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 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

Tip Colour: Red  
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:	30 - 40	40 - 60	45 - 80	80 - 120	120 - 150	160 - 180		



≡ HIGH QUALITY WELDING PRODUCTS ≡

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