



EAGLE 206

Wear Resistant Aluminum Bronze Electrode

APPLICATIONS

For joining and repair of gears, impellers, valve bodies, ship propellers, blades and hydraulic parts.

PROCEDURE

Use DC Reverse [+] Polarity. Clean all weld areas with a grinder. Preheat thick sections to 600°F and maintain a short arc length. Allow weld to cool slowly and remove slag between passes.

GENERAL CHARACTERISTICS

The **EAGLE 206** is an aluminum bronze electrode that produces a smooth arc that deposits dense porosity free welds.

TECHNICAL DATA

Tip Colour: Red
Tensile Strength: Approx. 100,000 psi
Elongation: Approx. 15 - 20%
Hardness: (BH) Approx. 200

WELDING PARAMETERS

Current:	DC Reverse [+] Polarity			
Sizes:	Inches	3/32	1/8	5/32
	mm	2.50	3.25	4.00
Amperage:	75 - 90	90 - 120	150 - 190	



≡ 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

REVISED 01 2024