



EAGLE HDR

*The Eagle Heavy Duty Repair Is A **MOISTURE RESISTANT** All Position Controlled Low Hydrogen Electrode For Welding Steels Sensitive To Cracking*

APPLICATIONS

For welding of general structural steels, pipe steels, steel castings, carbon steels, fine-grained steels and high carbon steel. The weld deposits are crack free and of x-ray quality.

PROCEDURE

Use AC or DC Reverse [+] Polarity. Clean weld areas with a grinder and groove out the cracks using the **EAGLE 188**. Vertical welds should be welded from bottom up using the stringer bead technique for maximum strength. A medium arc length should be maintained while welding.

GENERAL CHARACTERISTICS

The **EAGLE HEAVY DUTY REPAIR** is an extremely smooth **MOISTURE RESISTANT** electrode with excellent impact properties, even at sub zero temperatures. This electrode has a stable arc, smooth deposit and very little spatter.

TECHNICAL DATA

Tip Colour: Blue
 Tensile Strength: Approx. 86,000 - 88,000 psi
 Yield Strength: Approx. 75,000 - 76,000 psi
 Elongation: Approx. 30 - 32%

WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity				
Sizes: Inches	3/32	1/8	5/32	3/16	1/4
mm	2.50	3.25	4.00	5.00	6.00
Amperage:	60-100	110-150	140-190	210-280	290-375



≡ HIGH QUALITY WELDING PRODUCTS ≡

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