

# HABCO SA 111 (S)

**PREMIUM ALL-PURPOSE ELECTRODE FOR WELDING  
 LOW CARBON AND MILD STEELS. SUPERIOR DEPOSIT  
 APPEARANCE WITH SELF-RELEASING SLAG.  
 ALL-POSITION, EASY TO USE**

## FEATURES

Produces high quality weld deposits with superb bead appearance, regardless of power source, current or polarity. Arc is quiet, producing a spray type deposition with a high degree of arc ionization. Superior wash in filletting applications.

## APPLICATIONS

Fabrication of thin, medium, heavy and dissimilar gauge mild steels. Sheets, plates, angle iron, beams, pipes and machine parts can be welded in all positions. Also used for filling holes and build up of over-machined and worn surfaces. Commonly used on all applications requiring short, intermittent and spot welds because of the outstanding restarting characteristics.

## INSTRUCTIONS

Remove as much foreign material as practical from the weld area. DC reverse polarity (electrode +) produces deep penetration: DC straight polarity (electrode -) will have limited penetration and a flatter bead. AC prevents arc blow. A medium arc length should be maintained with either stringer or weave beads. Slag is easily removed and self-releasing.

**Tensile Strength: up to 80,000 Psi (56 kg/mm<sup>2</sup>)**

**Yield Strength: up to 68,000 Psi (47 kg/mm<sup>2</sup>)**

**Elongation: approx. 24%**

**Current: AC or DC ±**

<b>Amperage:</b>	<b>20-50</b>	<b>25-60</b>	<b>35-80</b>	<b>65-125</b>	<b>90-160</b>	<b>120-210</b>
<b>Diameters: (in)</b>	<b>1/16</b>	<b>5/64</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>1.6</b>	<b>2.0</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>

• Available in TIG form