

HABCO SA 113 (S)

UNIVERSAL ELECTRODE FOR WELDING RUSTY AND SCALY STEEL IN ANY POSITION

FEATURES

A superior all position, all purpose, maintenance electrode designed for easy all position operation on rusty, dirty, or painted steels. The forceful arc drive produced by this electrode, burns through weld zone contamination, depositing a deeply penetrating, porosity-free weld. No slag removal required between passes on multi-pass deposits.

APPLICATIONS

General welding of all structural steels and mild steel pipe. Ideal for use on painted and galvanized surfaces, or **for everyday maintenance welding**. Works well where fit up is poor, or when slag interference must be minimized. Exceptional ability to operate under severely adverse conditions.

INSTRUCTIONS

Using DC reverse polarity (electrode +) produces deep penetration; DC straight polarity (electrode -) will limit penetration and flatten weld bead. AC prevents arc blow. A medium arc length should be maintained when using either stringer or weave beads.

Tensile Strength: up to 88,000 Psi (62 kg/mm²)

Yield Strength: up to 80,000 Psi (56 kg/mm²)

Elongation: approx. 28%

Current: AC or DC ±

Amperage:	40-80	75-125	110-180
Diameters: (in)	3/32	1/8	5/32
(mm)	2.5	3.25	4.0