



## **WELDCOTE 900**

### **Hardfacing Electrode for Abrasion and Moderate Impact**

**DESCRIPTION:** **WELDCOTE 900** is a low hydrogen, all-position, hardfacing electrode for high stress steels. This electrode has a quite arc, creates very little spatter and is often used as a low cost alternative to high cost alloys. **WELDCOTE 900** is commonly used in structural steel fabrication and is an ideal choice for joining carbon steel, low and medium alloy high tensile steels and cold rolled steel.

**PROCEDURE:** Use either AC or DC+ reverse polarity. Clean the weld area. For DC+ (reverse polarity) bevel heavy sections to a 60° Vee. Hold the electrode at a slight angle in the direction of travel and use a weaving technique, but do not exceed 3 time the diameter of the wire. Use a straight forward progression for all position welding. Slowly cool high carbon steels and remove slag between passes.

**FEATURES:** Tensile strength: up to 80,000 psi  
Yield strength: up to 68,000 psi  
Elongation: 20-40%  
Hardness as Deposited: 55-60 RC  
Corrosion and heat resistance: GOOD

**PACKAGING:** **WELDCOTE 900** is available in 1/8 and 5/32 diameters, packed in ten pound tubes, four tubes per forty pound carton.



## **WELDCOTE 2300**

### **Premium, Multi-Purpose Phosphor Bronze Electrode (AC-DC)**

**DESCRIPTION:** WELDCOTE 2300 is a versatile, copper-based alloy for buildup and joining. This electrode joins copper, brass, bronze and dissimilar metals. It offers excellent resistance to frictional wear when used as an overlay. WELDCOTE 2300 is used in numerous applications, included, but not limited to, the repair of bearings, bushings, gears, propellers, impeller blades and couplings.

**PROCEDURE:** Use either AC or DC reverse polarity. Clean weld area. Copper and heavy sections of cast iron must be preheated. Preheat of phosphor bronze castings should be approximately 400° F and copper should be preheated to approximately 750° F. Preheat must be maintained while welding. Use lowest current for sound weaving technique. Once the weld is cooled, slag may be removed by chipping and brushing. Cool slowly.

**FEATURES:** Tensile strength: up to 65,000 psi  
Color matches red bronze  
Frictional Resistance: Excellent  
Machinability: Excellent

**PACKAGING:** WELDCOTE 2300 is available in 1/8 diameter, packed in ten pound tubes, 40 lbs per master carton. **Amperage** 60-120 amps.