XL Gold™
Duplex Alloy Electrode
XL Gold is the standard in all-steel maintenance welding electrodes. XL Gold has higher strength, excellent elongation and superior weldability. It is easier to use, the slag is self-lifting, and the deposit has tougher crack resistance. XL Gold is the latest generation in all-steel welding electrodes.
- Tougher welds - Duplex alloy with maximum crack resistance
- Higher tensile strength – 186,000 psi work hardened
- Improved welder appeal and slag removal with the exclusive Chem-A-Tized² process
- Designed for welding difficult-to-weld steels like alloy steels and dissimilar types of steel
- All-position welding

SPECIFICATIONS
Tensile strength ................................................................. Up to 186,000 psi work-hardened/1282 MPa
Yield strength ........................................................................... Up to 128,000 psi as deposited
Elongation ....................................................................................... Up to 90,000 psi/620 MPa
Reduction of area .............................................................................. 32%
Machinability ...................................................................................... 25%
Corrosion resistance ........................................................................... Good
Hardness ............................................................................................ As deposited 97Rb
Work-hardened .................................................................................. 35 Rc
Impact resistance ................................................................................ 100 ft-lbs. @ 75°F/25°C
Heat resistant ..................................................................................... Good up to 750°F/399°C
Current .................................................................................................... AC or DCEP (DC+)

PROCEDURE
Remove defective metal by grinding or gouging with Arc-Prep #161 electrode. Bevel heavy sections before welding. Use AC or DCEP current. Use a contact or a minimum arc length with a weave or stringer bead technique. Preheat should be used when the base metal requires it. For vertical-up welds reduce amperage slightly and use a modified weave technique. Chip the slag between multipass welds. Allow to cool slowly.

APPLICATIONS
- Joining dissimilar alloy steels
- Joining difficult to weld steels
- Joining steel to stainless
- Joining tool steel to steel
- Joining steels to nickel alloys
- Joining steel to cast steel
- Repairing tool steel
- Joining spring steel to steel
- Dragline bushings
- Dragline hoist trunion links

INDUSTRIES
- Trucking
- Mining
- Petrochemical
- Railroad
- Manufacturing
- Heavy equipment used in earth moving

<table>
<thead>
<tr>
<th>Code #</th>
<th>Diameter</th>
<th>Amperage</th>
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<td>001-3-0006</td>
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