



XL Gold™ Duplex Alloy Electrode

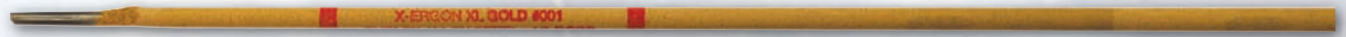
XL Gold is the standard in all-steel maintenance welding electrodes. XL Gold has higher strength, excellent elongation and superior weldability. It is easier to use, the slag is self-lifting, and the deposit has tougher crack resistance. XL Gold is the latest generation in all-steel welding electrodes.

- 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
.....	Up to 128,000 psi as deposited
Yield strength.....	Up to 90,000 psi/620 MPa
Elongation	32%
Reduction of area.....	25%
Machinability.....	Good with carbide tools
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+)



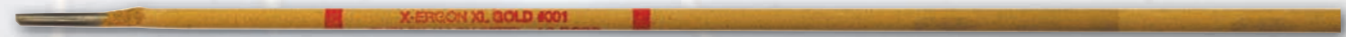
PROCEDURE

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

Code #	Diameter	Amperage
001-3-000G	5/32"	95-145
001-4-000G	1/8"	60-100
001-5-000G	3/32"	35-70

