

SuperBlue Covered Electrode

◆ INTRODUCTION

Aufhauser SuperBlue covered electrode is a versatile, multi-purpose electrode, suitable for welding wrought and cast alloys such as high carbon, tool steels, stainless steels, spring steels, manganese steels and dissimilar steels. This alloy gives a two-phase weld deposit with substantial amounts of ferrite in an austenitic matrix. This alloy has excellent impact and frictional resistance with high heat resistance and mild abrasive resistance.

◆ APPLICATIONS

- Wrought and cast alloys, problem steels such as high carbon, tool steels, stainless steels, spring steels, manganese steels.
- Dissimilar steels.

◆ CHEMICAL COMPOSITION

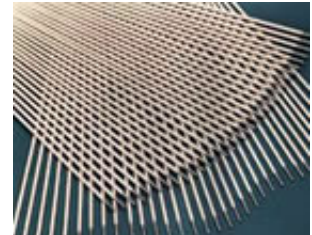
(AWS A5.22)

	<u>Carbon</u>	<u>Chromium</u>	<u>Nickel</u>	<u>Molybdenum</u>	<u>Manganese</u>	<u>Silicon</u>	<u>Phosphorus</u>	<u>Sulfur</u>	<u>Copper</u>
Typical	.15	28-32	8-10.5	.5	.5 – 2.5	1.0	.04	.03	.5

Note: All values are maximum percentage, unless shown in range.

◆ PHYSICAL and MECHANICAL PROPERTIES

Tensile Strength:	120,000 psi
Yield:	85,000 Psi
Elongation, min. %:	35
Average Impact Strength%:	29



◆ RECOMMENDED WELDING PARAMETERS:

<u>Wire Diameter</u>	<u>Amps</u>
3/32	40-80
1/8	70-110
5/32	95-145
3/16	145-200

◆ SPECIFICATIONS MEET or EXCEED

- ANSI/AWS A5.22 (E312)

◆ STANDARD SIZES AND DIAMETERS

Diameters
 3/32", 1/8", 5/32", 3/16"