

Addifix 770

HIGH RECOVERY ELECTRODE FOR JOINING AND BUILDING UP MANGANESE STEEL (AC/DC+)

Tensile Strength:	105,000-115,000 PSI		
Elongation:	30 – 36 percent		
Hardness:	work hardens to approximately 450 brinell		
Diameters:	1/8	5/32	3/16
Amperages:	120	170	225

Superior build-up on Manganese and Carbon steels. Formulated exclusively for construction equipment to resist extreme shock and impact. Excellent as cushion on Manganese in order to support layers of ADDIFIX 740.

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- Extremely tough work hardening steel.
 - Resists **extreme shock**, impact and moderate abrasion.
 - The harder and more often it is hit, the better the wear resistance.
 - Low spatter.
 - Smooth arc deposition.
 - Easy slag removal.
 - Best used in the horizontal or flat position.
 - As many layers as necessary may be superimposed for buildup.
 - Excellent as a cushion under harder, more brittle hard-facing alloys.
 - Deposit flows on smoothly.
 - Much less smoke than with other buildup electrodes.
 - Flame cuttable.

MADE IN USA

Typical Industrial Applications: Impact breaker bars, hammer mill hammers, excavating buckets dippers-shovels-teeth-lips, wheel excavator teeth. Manganese rail track work-frogs-switches, crossovers, rail ends, railcar castings, crusher rolls, crusher mantles, and jaw crushers, grizzly bars, other mining and heavy construction equipment. Constructing and repairing Manganese shot blast liners.

Note: Always keep High Manganese under 500 degrees F.