

# Addifix 930

## THE SUPER STRENGTH ELECTRODE FOR "CRACK FREE" WELDING OF ALL ALLOY AND CARBON STEELS (AC/DC+)

Tensile Strength:	100,000-120,000 PSI
Elongation:	26-30 percent
Hardness:	as welded 250 brinell
Diameters:	3/32 1/8 5/32
Amperages:	80 120 15

Super strength problem solver for "Crack-Free" welding of all alloy and carbon steels. Remarkable strength and elasticity even on difficult to weld steels. Weldments are corrosion and heat resistant. Trouble free joining of high Carbon, Manganese, tool and other steels of unknown compositions. Excellent for building up and cushioning.

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- Super strength weldments to withstand 120,000 pounds per square inch of pulling force.
  - Join and buildup *high alloy and high carbon* steels without fear of weld cracking. This includes manganese steels, stainless steels, and many tool steels.
  - Welds remain both strong and highly ductile.
  - Join all types of steels whether known or unknown, similar or dissimilar.
  - Corrosion and heat resistant.
  - Wear resistant.
  - Easy to strike and restrike.
  - For all position welding.
  - Used by all industries as the "problem solver."

**MADE IN USA**

Typical Industrial Application: Joints, springs, axles, shafts, gears, dies, armor plate, Manganese steel, stainless steel, tools, rails, crane booms, chain links, jigs, fixtures, machine parts, levers, cams, lift truck forks, clamps, and grips.

Note: Should the removal of a super strength 930 weldment ever be necessary, use ADDIFIX 120 cutting electrode.

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## Simple step by step instructions on how to remove broken bolts, studs, drills, and taps

1. Choose correct size of electrode to suit hole diameter. Set amperage according to chart below.

HOLE SIZE	ELECTRODE SIZE	RECOMMENDED AMPERAGE
Up to 3/8" (9.5mm)	Use 3/32" (2.4mm)	50-75 amps.
From 3/8" to 1/2" (9.5-13mm)	Use 1/8" (3.2mm)	80-120 amps.
Over 1/2" (13mm)	Use 5/32" (4.0mm)	100-140 amps.

2. See Figure 2. Strike arc precisely in center of broken part and begin to build-up. Take your time. Continue re-striking "dead-center" on build-up. Building-up deposit off-center will cause stud to be welded to part. Do not overheat. Allow build-up to cool.
3. Before building deposit outside of hole allow weld deposit to cool. This precaution will help avoid welding deposit to top edges of hole.
4. Carefully chip away only top center of slag and continue to build deposit above top edge of hole. You need enough build-up to weld a nut and washer to deposit, without welding them to part edges.
5. See Figure 3. Allow deposit to cool slightly. Weld another washer and nut, of same or smaller size than stud, to deposit by striking arc inside nut and washer in center of deposit. *Be careful not to weld this assembly to part edges.*
6. See Figure 4. Allow assembly to cool before using a wrench, or appropriate tool, to remove broken part. If there are any problems removing broken part, weld deposit build-up was improperly centered.
7. Slag is easily chased from hole by using a tap.

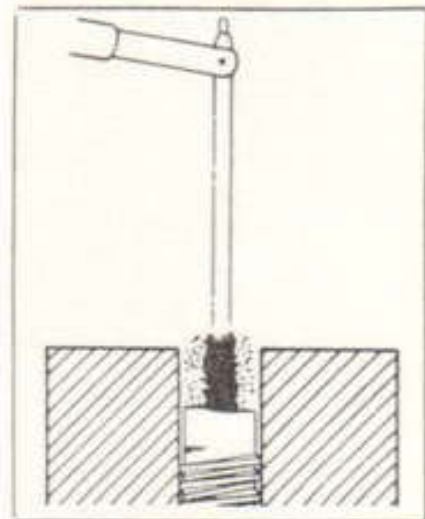


FIGURE 2

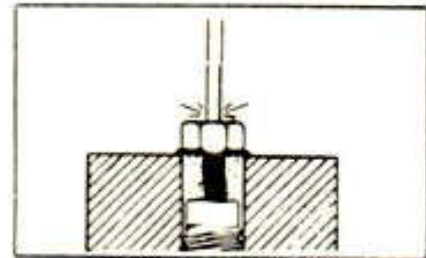


FIGURE 3



FIGURE 4