

Addifix 960

**FULLY CONSUMABLE, EASY TO USE,
ELECTRODE FOR WELDING STEELS SUBJECTED
TO HIGH HEAT OR CORROSIVE ENVIRONMENTS
(DC+)**

Tensile Strength:	as welded 28 Rockwell "C"
Elongation:	23-27 percent
Diameters:	3/32 1/8 5/32
Amperages:	85 120 160

Resist oxidation and carburizations to 2150°F. Unusual stabilized flux eliminates stub loss. Easy to use, does not stick and restrikes instantly. Resists extreme thermal cycling. Use to weld nickel base, nickel-iron-chromium base, carbon steel, stainless steel, nickel-copper alloys and dissimilar combinations of these alloys.

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- Use 960 to weld nickel base, nickel iron chromium base, carbon steel nickel copper alloys and dissimilar combinations of these alloys.
 - Resists oxidation and carburization to 1250°F.
 - 100,000, P.S.I. high tensile strength joints.
 - Special stabilizers similar to those used in ADDIFIX stainless enables use of the *whole* electrode without overheating, without stopping and eliminates stub loss.
 - Very easy to use, runs on contact.
 - An all position electrode with excellent control of the molten puddle.
 - Does not stick and restrikes instantly.
 - Smoothly feathering deposit builds up quickly.
 - Free from undercut.
 - Smooth and steady arc action.
 - Eliminates burn-through on thin gauge.
 - Excellent bead shape with practically no spatter.
 - Very good sub-zero properties to combat extreme thermal cycling applications.

MADE IN USA

Typical Industrial Application: Heat treat baskets, quench trays, heavy pipe flanges, flame hardening equipment parts, furnace muffles, combustion tubes, heating coils, steam boilers, chemical plant applications and Inconels.

Note: Cleanliness is essential. The alloys are susceptible to embrittlement. Remove all dirt, grease, oil, paint, lubricants, marking crayon, etc., with Acetone or other degreaser before welding.