

weldcote 
metals

**Maintenance and Repair Alloys for
Welding, Brazing, Soldering and
Metal Working**



Weldcote Metals Maintenance and Repair Alloys for Welding, Brazing, Soldering and Metal Working

Dissimilar metal combinations - 120,000 psi tensile

Super 120 Electrodes are excellent for repairing tools, dies, spring steel and any dissimilar metal combinations, except for aluminum and copper alloys due to exceptional strength and crack resistance. Super 120 is also recommended for repairing worn parts and as an underlay for hardfacing.

Applications: repairing tools, dies, spring steel and any dissimilar metal combinations. Consider this the maintenance and repair “stand-by” in every industry throughout the world.

Procedure: Use either AC or DC reverse polarity (electrode +). The weld area should be free of rust, grease, paint and other materials which cause weld contamination. A 90° vee joint should be used when joining heavy sections. Maintain a short arc length and use stringer beads. For high carbon steels, a preheat of 400° is recommended. Weld positions are flat, horizontal, vertical up and overhead.

Amperages: 3/32" = 35 – 70 1/8" = 60 – 110 5/32" = 75 – 140 3/16" = 130 - 200

Super 120 3/32 electrode Super 120 1/8 electrode Super 120 5/32 electrode	4-10 lb tubes in 40 lb ctn	SUPER120332E SUPER12018E SUPER120532E
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Aluminum cast & wrought base metal

Aluminum Smooth 340 Maintenance and Repair electrodes feature a precise combination of core wire and coating, providing high speed deposition of dense, machinable welds. It is recommended for fabrication and repair of cast and wrought aluminum. It is excellent for foundry defects, machining errors and all types of salvage work.

Applications: It is widely used on sheets, tubes and extrusions in thickness of 1/8" or more. Smooth 340 is also well-suited to torch applications such as aluminum motor blocks and cylinder heads, machine bases and supports, housings and mounts.

Procedure: Use DC reverse polarity. Weld areas should be clean and heavier sections should be beveled. Best results will be obtained on heavier sections when preheated to 500°F. The electrode should be held in a vertical position. Slag needs to be removed before multiple passes. Clean with hot water; add 10% sulfuric acid to water if additional cleaning is required.

Amperages: 3/32" = 50 – 85 1/8" = 80 – 135 5/32" = 100 - 165

Aluminum Smooth 340 3/32 electrode Aluminum Smooth 340 1/8 electrode Aluminum Smooth 340 5/32 electrode	4 – 5 lb tubes in 20 lb ctn	ALSMOOTH340332E ALSMOOTH34018E ALSMOOTH340532E
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Quick & easy self-starting electrode (Spot Arc)

Spot Arc Electrodes are a quick and easy self-starting contact electrode for low amperage needs such as spot welding guns. Spot Arc electrodes are the only mild steel electrode offering the convenience of flat, vertical up and down, and overhead without changing amperage settings. Spot Arc Electrodes can be bent without flux breakage. Contact (drag) type transfer allows the electrode to weld by itself. It is a versatile all around repair and fabrication of clean, well fitting common mild steel components with fast freeze slag characteristics to ensure fully positional operability.

Applications: Ideal for low amperage needs such as spot welding guns: Sheet metal, automotive body work

Procedure: DC Straight (-), Reverse (+), or AC. Welding positions are flat, vertical up, vertical down, horizontal and overhead. Contact (drag) type transfer allows the electrode to weld by itself.

Amperages: 1/16" = 20 – 30 5/64" = 50 – 70

Spot Arc 1/16 electrode	4-5 lb tubes in 20 lb ctn	SPOTARC116E
Spot Arc 5/64 electrode		SPOTARC564E

88-83 High Performance High Tensile - All Position Electrode (AC-DC)

88-83 Electrodes are a high performance, all position, trouble free, steel electrode with higher tensile strength and elongation than ordinary mild steel electrodes. 88-83 can be used on many mild or low alloy steels. Use AC or DC reverse polarity. The tensile strength is up to 88,000 psi and elongation up to 24% in 2".

Applications: Auto and truck bodies, trailer flooring, tanks, frames, guards, non-critical piping, shelving, farm implements, furniture repairs, etc.

Procedure: Use AC or DC reverse polarity. Remove all foreign matter from base metal for best performance. Holding a short arc will minimize heat buildup and distortion. Remove slag between passes by light chipping. Straight stringer welds can be used in the flat, horizontal and vertical down positions. For vertical up, a slight weave technique is recommended.

Amperages: 1/8" = 80 – 120 5/32" = 110 – 150

88-83 1/8 electrode	4-10 lb tubes in 40 lb ctn	888318E
88-83 5/32 electrode		8883532E



10-P Stainless Steel Electrodes for High Strength, corrosion resistance on dissimilar stainless steels

10-P Electrodes are a versatile electrode for high strength, corrosion resistant welds on stainless steels. 10-P characteristics: Tensile strength up to 88,000 psi, yield strength 63,000 – 68,000 psi, excellent corrosion resistance and excellent heat resistance.

Applications: 10-P is a special formulation for joining and fabricating stainless steels. 10-P is most desirable when dissimilar stainless steels are joined and the deposit is not required to be identical to the base metal. 10-P is a good option in applications where the analysis of the stainless is unknown.

Procedures: Remove all scale, dirt and grease from the weld area. Heavier sections should be beveled. Hold a short arc, run stringer beads. Slag is easily removed by chipping between weld passes.

Amperages: 3/32" = 40 – 80 1/8" = 70 – 110 5/32" = 100 – 140

10-P 3/32" x 12" electrode	3/32" - 5 lb tubes, 20 lb ctn / Other diameters 4-10 lb tubes in 40 lb ctn	10P332E
10-P 1/8" x 14" electrode		10P18E
10-P 5/32" x 14" electrode		10P532E

Nickel 55 (AWS Class ENiFe-CI)

Nickel 55 has a lower nickel content than Nickel 99 electrodes (nominally 55%). Weld deposits are usually machinable, but under conditions of high admixture, the welds can become hard and difficult to machine. Nickel 55 welds are stronger, more ductile and more tolerant of phosphorus in the casting. It also has a lower coefficient of expansion than Nickel 99 resulting in fewer fusion line cracks.

Applications: Nickel 55 is usually used to repair castings with heavy or thick sections such as motor blocks, housings, machine parts, frames, defective castings and building up worn sections.

Procedure: AC or DC (DC+), all position. A preheat and inter pass temperature of no less than 350°F (175°C) is required during welding. Lightly peen between passes and use a skip or back-step welding technique. Allow casting to cool slowly.

Amperages: 3/32" = 65 – 75 1/8" = 90 – 105 5/32" = 120 – 135 3/16" = 135 - 155

Ni 55 3/32 electrode	4-10 tubes in 40 lb ctn	NI55332E
Ni 55 1/8 electrode		NI5518E
Ni 55 5/32 electrode		NI55532E
Ni 55 3/16 electrode		NI55316E



Nickel 99 (AWS Class ENi)

Nickel 99 is a nominally 99% nickel electrode. Nickel 99 deposit welds are machinable, which is an important criterion when the casting is to be machined after welding. Repairs with Nickel 99 are often single pass welding with high admixture. Even with high admixture, the weld deposit will remain machinable.

Applications: Nickel 99 works best on castings with low or medium phosphorus contents such as thin plates, machinery parts, frames and housings

Procedure: AC or DC reverse or straight polarity. Must have clean weld area. Bevel breaks and cracks deep enough so the first pass ties in the bottom of the crack. In most cases, preheating is not necessary, but heavy sections should be preheated to approximately 400°F. Use a short arc and stringer beads are recommended. Skip or back-step weld and peen to relieve stresses. Allow the casting to cool slowly.

Amperages: 3/32" = 65 – 75 1/8" = 90 – 105 5/32" = 120 – 135 3/16" = 135 - 155

Ni 99 3/32 electrode	4-10 tubes in 40 lb ctn	NI99332E
Ni 99 1/8 electrode		NI9918E
Ni 99 5/32 electrode		NI99532E
Ni 99 3/16 electrode		NI99316E

Multi-Purpose Phosphor Bronze Electrode

Weldcote 2300 Phosphor Bronze Electrodes are a versatile, copper based alloy that joins copper, brass and dissimilar metals. Weldcote 2300 is used for buildup, joining and repairs of many surfaces needing a frictional resistance of buildup finish. When used as an overlay, it offers excellent resistance to frictional wear.

Applications: It is typically used for the repair of bushings, gears, propellers, impeller blades, couplings and numerous other applications

Procedures: Use either AC or DC reverse polarity. Clean weld area. Copper and heavy sections of cast iron must be preheated. Preheat of phosphor bronze castings should be approximately 400°F and copper should be preheated to approximately 750°F. Preheat must be maintained while welding. Use lowest current for sound weaving technique. Once the weld is cooled, slag may be removed by chipping and brushing.

Amperage: 1/8" = 60 - 120

Weldcote 2300 1/8 electrode	4-10 lb tubes in 40 lb ctn	230018E10
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Nickel free - Cast Iron and Steel - poor conditions (oily, burned)

Weldcote 2800 Nickel Free Cast Iron Maintenance and Repair is a non-machinable cast iron electrode found in repairs or joining steels and cast iron that may be oily, greasy, burned out casting and many other poorly cleaned base metals.

Applications: For joining problem cast iron to steel. Uses such as cracked machine bases, pump housings, burned furnace grates and low quality cast iron.

Procedure: Use either AC or DC reverse polarity. Clean weld area, remove surface contaminates and sharp edges. Bevel joint to form a "U" groove. A bead hole must be welded at right angles to each end of all cracks to prevent spreading during welding. Use low amperage and maintain a short arc. Short stringer beads or narrow weave beads should be used to prevent excessive heat buildup. When breaking the arc always fill the crater and drag rod back over the weld deposit. Peening while still hot will help reduce stresses. When restriking the arc, start on previously deposited weld metal, not on the base material. Allow part to cool slowly.

Amperage: 1/8" = 75 - 110

Weldcote 2800 1/8 electrode	4-10 lb tubes in 40 lb ctn	280018E
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Hard Facing Electrode – Impact and Severe Abrasion - Hardness of RC

Weldcote 900 Hard Surfacing Electrodes are a general purpose hard facing rod with low hydrogen and high strength for high stress steels. The Rockwell range is 55 – 58 depending on the carbon content of the base metal. It can be used for buildup and hardfacing to provide weld deposits capable of resisting a variety of wear types ranging from metal to metal wear to severe abrasion.

Applications: build up on shovel and bucket lips, pump impellers and housings, pulverizer plows and mill hammers. Hardfacing on trunions, tractor rolls, cranes and gears.

Procedures: AC or DC. Remove fatigued metal and clean remaining oxides and debris. Using AC or DC to deposit stringer or weave beads as needed. Deposits can be forged at medium heat. Use straight polarity (DCEN) for highest buildups.

Amperage: 1/8" = 90 – 120 5/32" = 130 – 160

Weldcote 900 1/8 electrode	4-10 lb tubes in 40 lb ctn	90018E
Weldcote 900 5/32 electrode		900532E

Gouging, Veeing, Scarfing and Removal of Metals

Chamfer Arc Electrodes are used for gouging and cleaning of faulty welds of metals like cast iron, stainless steels, and aluminum for which the oxy-acetylene method is not applicable. Chamfer Arc is a heavily coated special gouging electrode which is very easy to use.

Applications: Gouging and chamfering of ferrous and non-ferrous metals. Chamfer Arc electrodes are ideal for removing unwanted or defective weld metal, preparing parts prior to welding, removing risers and reducing large areas of metal prior to machining. Also used when oxy-acetylene is not applicable.

Procedures: AC or DC straight polarity. For arc start, hold electrode perpendicular and then leaned 15° and pulled forward. Chamfer Arc electrodes should not be pushed into the work more than half the coating thickness. If the groove is not deep enough, the process should be repeated after the work piece has cooled.

Amperage: 1/8" = 210 – 350 5/32" = 250 – 400 3/16" = 300 - 500

Chamfer Arc 1/8 electrode	3-8 lb tubes in 24 lb ctn	CHAMFERARC18E
Chamfer Arc 5/32 electrode		CHAMFERARC532E
Chamfer Arc 3/16 electrode		CHAMFERARC316E

High Speed Cutting, Trimming, Piercing and Removing Metals with Welding

Cut Rod is a special cutting electrode with a heavy coating. Arc start and welding are easy with this electrode and it can be used with high currents. Cut Rod should be positioned perpendicular to the work and used in cutting and gouging of metals like cast iron, aluminum, and stainless steels.

Applications: This electrode is frequently used for removing rivets and bolts, enlarging openings, trimming metals, etc.

Procedures: AC or DC straight (electrode -) For the fastest and cleanest cuts, use DC straight polarity (electrode -). When piercing, hold electrode vertical to work, strike arc, and push in and out until hole has been formed. When cutting sheets or plates, start at the edge, strike arc, and use electrode like a saw; push and pull with the electrode at a 45° angle to the work piece. In all cases the arc must be kept as short as possible.

Amperage: 1/8" = 140 – 350 5/32" = 175 – 400 3/16" = 225 – 450

Cut Rod 1/8 electrode	4-8 lb tubes in 32 lb ctn	CUTROD18E
Cut Rod 5/32 electrode		CUTROD532E
Cut Rod 3/16 electrode		CUTROD316E

Metal Removal on Practically Any Metal

Arc Gouging Carbon Electrodes are copper clad and designed specifically for the air carbon arc process. They are a flexible, efficient and cost effective way for metal removal on practically any metal: carbon steel, other ferrous alloys, cast iron, aluminum, nickel, copper alloys and other nonferrous metals.

Applications: Metal removal on practically any metal; creating "U" grooves for weld joints, gouging out cracks, removing hard surface materials, removing old welds and many other applications.

Procedure: AC or DC. The electrode should extend at most 7" from the gouging torch with the air jet between the electrode and work piece. Rod angle to work is 35° to 45°. Always use the push technique. The depth and contour of the groove produced are controlled by the electrode diameter and travel speed. Groove depths greater than 1-1/2 times the diameter must be in multiple passes. The width of the groove is determined by the electrode diameter used and is usually 1/8" wider than the diameter. Consult carbon arc torch manual for air pressure settings.

Amperage: 5/32" = 90 – 150 3/16" = 200 – 250 1/4" = 300 – 400 5/16" = 350 – 450 3/8" = 250 - 450

Gouging carbons 5/32 X 12	100 pcs per box 500 pcs per case	GCARBONS532X12
Gouging carbons 3/16 X 12	50 pcs per box 250 pcs per case	GCARBONS316X12
Gouging carbons 1/4 X 12		GCARBONS14X12
Gouging carbons 5/16 X 12		GCARBONS516X12
Gouging carbons 3/8 X 12		GCARBONS38X12

High Strength Fluxless Zinc Alloy Solder for Pot Metals, Zinc & Aluminum

Alumite is a fluxless brazing rod for the fabrication, maintenance and repair of aluminum alloys, zinc die cast, pot metal and white metal. It is also an excellent general purpose high strength solder.

Applications: Aluminum alloys, zinc die cast, pot metal and white metal such as machine bases and supports, housings, mounts, and can buildup and fill in areas. It can also be used as a high strength solder.

Procedure: Clean joint of as much residual debris, grease or other contaminants as possible. Break surface oxides by mechanical means (scratching, scraping, etc), bevel heavy sections and use fixtures or jigs to hold parts in alignment. With a slightly carburizing flame, heat the base metal to working temperature of the alloy taking care to keep the flame moving. Apply alloy by rubbing the rod against heated base metal. Do not heat the rod directly. Allow the part to cool before removing from fixtures.

Alumite 1/8	4-5 lb tubes in 20 lb ctn	ALUMITE18
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Aluminum All Purpose Flux Cored Brazing Rod

Flux Cored Aluminum for Maintenance and Repair (Tubular aluminum rod) is an all purpose brazing/braze welding alloy for oxy-acetylene applications to aluminum. Flux percentage is ideally calculated to optimize use in joining wrought for filling in and building up on aluminum castings. Flux Cored Aluminum has a virtually seamless, closed tube, thus protecting the active flux core from the atmosphere.

Applications: Flux Cored Aluminum is ideal for joining all brazable grades of aluminum sheet, plate, tubing, piping, extrusions, rods and wires. It can be used to repair brazable aluminum castings, filling in holes, building up worn or missing sections and joining cast to wrought parts. General purpose outdoor use on repairing aluminum skids, platforms, loading docks, truck bodies, irrigation piping, fences and railings whenever inert gas welding or shielded metal arc welding is impractical.

Procedures: Remove oxides and foreign material from weld area preferably by mechanical means (scraping, filing, etc). Bevel parts thicker than 3/16" to form a 60° vee. With the oxy/fuel torch adjusted to a slightly carburizing flame, heat work broadly to about 1000°F. Melt ¼" of the rod off onto the work piece (the flux will also turn to a liquid); continue heating until alloy flows out. Lower the angle of the torch; continue adding alloy a drop at a time until weld is complete. Allow part to cool slowly. Remove all flux residue with stiff brush and hot water.

Flux-Cored Aluminum 1/8 X 32"	4-5 lb tubes in 20 lb ctn	FCALUM18
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Cast Iron Alloy Fusion Welding Rod

Cast Iron Rod is a high quality gray iron oxy-acetylene welding rod designed for gas welding of cast iron, general fabrication or buildup new or worn surfaces on castings. Cast Iron Rod produces machinable weld deposits that have the same color, composition and granular structure as the base metal (gray iron). The weld, if properly made, can be as strong as the original casting.

Applications: For gas welding of cast iron in fabrication or buildup on new or worn surface on castings. Cast Iron rod is used to repair machine bases, manifolds, engine blocks, cylinder heads and gear housings.

Procedures: Bevel heavy sections to form a 75° vee. Always use a neutral flame to prevent porosity due to oxidation of carbon. Preheat part to 800°F before starting to weld. Heat rod end, dip in Weldcote Cast Iron Flux and transfer to weld area (fusion welding). Melt off a small amount of rod; continue heating until deposit flows out. Add filler metal a drop at a time making sure each deposit is fused to the base metal; use Weldcote Cast Iron flux for good cleaning and protection. After welding allow part to cool slowly to prevent hardening and cracking.

Cast Iron Rod for Oxy-Fuel 1/4 x 18"	4-10 lb tubes in 40 lb ctn	CASTIRON14X18L
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Wear Resistant Alloy with Tungsten Carbide Particles

NiAg Carbide Composite rods are a wear-resistant alloy for gas welding maintenance and repair. This composite-type rod is made up of hard, sharp tungsten carbide particles. They are held in a shock-resistant, high-strength matrix to keep the carbide particles in place, even under extreme conditions. NiAg rods are to be used on steel, cast iron and copper alloys. When the exposed carbide chips become dull, they can be heated and repositioned to expose new, sharp edges to help reduce applications cost.

Applications: Ideal for overlay drills, reamers, bucket teeth, augers, stabilizer milling tools or any parts that take severe abrasion. Used extensively in the oil and earth moving industries where abrasion resistance and good impact qualities are important. Also used in the agriculture and dredging industries on mill hammers, plow shares, cultivate shovels, dredge bucket lips, dredge pump cutters, side pump plate and drive tumbler plates. Additional uses are in the brick and cement industries for crusher rolls, muller plows, shredder knives, pug mill knives and pipe forming shoes.

Procedures: Thoroughly clean base material of all debris and previous coatings. Grit blasted surfaces are preferable but not required. Use a large neutral flame to preheat base metal. Direct flame to rod until flux melts and alloy begins to flow out. Continue preheating part and applying alloy where desired. Rotating the rod during work will encourage even heating and carbide distribution. Allow part to cool slowly. Do not quench.

NiAg Carbide 3/16 X 1/8	4-10 lb tubes in 40 lb ctn	NIAG316X18
NiAg Carbide 3/16 X 1/4		NIAG316X14

Repairing Damaged Galvanized Materials - GALVINIZING-SOLDER

GALVINIZING SOLDER is a self-fluxing solder alloy for repairing damaged galvanized materials. It is very easy to apply and bonds to most metals. GALVINIZING-SOLDER will not peel or burn off and is superior to original galvanize. It has an excellent resistance to corrosion. Working temperature is about 600°F. Apply GALVINIZING-SOLDER while metal is still hot. A clean wire brush will aid in tinning surface with GALVINIZING-SOLDER. It can also be tinned with a paddle or cloth. Do not direct a flame on the alloy. Rub the rod on the metal, when it melts, the temperature is correct.

Applications: GALVINIZING-SOLDER rust-proofs burned and/or damaged galvanized coatings on sheet, bar or pipe. It is an excellent filler metal on rusty auto or truck bodies and cabs rather than plastics; also on all applications where parts cannot be disassembled to take to galvanizing tanks. It is used in field pipeline welding to prevent corrosion of welded areas.

Procedures: No flux is required. Apply GALVINIZING-SOLDER while metal is still hot. A clean wire brush will aid in tinning surface. It can also be tinned with a paddle or cloth. Do not direct a flame on the alloy. Rub the rod on the metal, when it melts the temperature is correct.

GALVINIZING-SOLDER 1/4" x 1/4" x 18"	4-5 lb tubes in 20 lb ctn	GALVSOLDER14
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MAINTENANCE & REPAIR ALLOYS COMPARISON CHART

For Welding, Brazing, Soldering and Metal Working

Weldcote Metals does not imply or infer that the materials listed are identical

WELDCOTE METALS	ALLSTATE	HARRIS WELCO	WASHINGTON ALLOY
SUPER120	275;Stud Plus	Super Missileweld	Tensileweld
ALUMINUM SM00TH 340	34	26	AL 345
SPOT ARC	-	315	Speedweld 300
NI-55	8-60	NIC-L-WELD 59	NICKEL55/CASCADE 18A
NI-99	8	NIC-L-WELD 99	NICKEL99/CASCADE 17A
88-83	Monoweld;Steelarc Plus	83-88	Super500
GALVINIZING SOLDER	Galvoer	GAL-VIZ	Galvbar
2300	24AC/DC	23	Rainer 3A
2800	6 IMP	28	EST/CASCADE 15A
900	Hard-Tuff 56	9	Super 700
CHAMFER ARC	Chamfer Rod	Chamfer Arc	Chamfer Arc Rod
CUT ROD	Cutting Rod	Cut Rod	Cut Rod
ALUMITE	53;55	52	Alu-Zinc
FLUX-CORED ALUMINUM	Sealcor	Cor-Al	Fluxcored Aluminum
CAST IRON ROD	3	Kast Weld 111	RCI
NI-AG CARBIDE	Ruf-Kut	Tuf Kut	30/40
10-P	252	P-10	310-16

WELDCOTE METALS	CERTANIUM	UTP	HI-ALLOY/INWELD
SUPER120	770SP;707	65	500;500ND/SA-1 BLUE
ALUMINUM SM00TH 340	608	48	35
SPOT ARC	-	-	-
NI-55	-	ECONOCAST 55	5; NI-55
NI-99	-	ECONOCAST 99	9; NI-99
88-83	702	612	Marvelweld/909
GALVINIZING SOLDER	Galvoplate	-	Galv Repair
2300	429	32	144/230;626
2800	885	81	64
900	250	67S	-
CHAMFER ARC	100	82	Metal Mover/414
CUT ROD	101	82-AS	Cut Arc/450
ALUMITE	61	41	155
FLUX-CORED ALUMINUM	68C	AL FC	FluxKored/230
CAST IRON ROD	81	5	290RCi;296
NI-AG CARBIDE	21	COMPOSITE TUNG ROD	105;Cutter Wear
10-P	709	68H	947

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WELDCOTE METALS	EUTECTIC	X-ERGON	MG
SUPER120	680	100XL/1000	Super 600;660
ALUMINUM SM00TH 340	2101;3021	141;Alumi-Arc	400
SPOT ARC	-	-	-
NI-55	2-23;232;235;555;3055	Castweld	260
NI-99	24X;240;3099;CASTEC	Castweld HPM	250
88-83	BEAUTYWELD;777	Duraweld Gold #106	500
GALVINIZING SOLDER	15	-	-
2300	28-280-2800	157;Arc-Braze	310AC;320DC
2800	27;QUENCHWELD B	-	220
900	N2;N61;N700;N1003	153;Abrade-X	760
CHAMFER ARC	EXOTRODE/QUENCHWELD A	161;Arc-Force	570
CUT ROD	Cut Trode #1	Arc-Prep	560
ALUMITE	19;196	243;Alu-Bond	470
FLUX-CORED ALUMINUM	21 FCE	242	420
CAST IRON ROD	14;141;144	-	240
NI-AG CARBIDE	88;8800;Drill Tec 88	-	788
10-P	Staintrode D;670	101	610

WELDCOTE METALS	ROCKMOUNT	UNIWELD	CRONATRON
SUPER120	BRUTUS A	5000	333;330
ALUMINUM SM00TH 340	NEPTUNE A	4000	510
SPOT ARC	-	-	-
NI-55	-	55	211
NI-99	-	99	222
88-83	TARTAN A	2000	338
GALVINIZING SOLDER	-	-	-
2300	VENUS A	1900	666
2800	JUPITER NM	3800	235
900	OLYMPIA A	6300	-
CHAMFER ARC	ELECTRA	2400	110/1100
CUT ROD	-	-	-
ALUMITE	NEPTUNE S	4200	52;53
FLUX-CORED ALUMINUM	NEPTUNE GCF	-	54C
CAST IRON ROD	JUPITER GC	-	22
NI-AG CARBIDE	OLYMPIA GT	-	75
10-P	GEMINI E	-	377

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