



## SUPER 120

**DESCRIPTION:** Due to exceptional strength and crack resistance, it is ideal for repairing tools, dies, spring steel and any dissimilar metal combinations, except for the aluminum and copper alloys. It is also recommended for repairing worn parts and as an underlay for hardfacing.

**PROCEDURE:** Use either AC or DC reverse polarity (Electrode +). The area in which the weld is to be made 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°F is recommended.

### CHEMICAL COMPOSITION PROPRIETARY

### MECHANICAL PROPERTIES

<b>Tensile Strength</b>	
132,300 PSI	910 MPA
<b>Yield Strength</b>	
94,000 PSI	660 MPA
<b>Elongation</b>	36%
<b>Impact Energy</b>	50J:68°F
<b>Hardness</b>	
Rockwell B-97	Brinell 320

**WELDING POSITION:** Flat, Horizontal, Vertical up, Overhead

### Amperages:

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

Weldcote Metals believes this data to be accurate and to reflect qualified expert opinion regarding current research. However, Weldcote Metals can not make any expressed or implied warranty as to this information.