



# MINERALS-TECH 911

## ALL POSITION ELECTRODE WITH DEEP PENETRATION AC or DC Either Polarity

### GENERAL CHARACTERISTICS:

The special coating allows this electrode to weld over extremely dirty, greasy, oil soaked, and rusty steels. Can be used for multi-pass welding without slag removal with no inclusions or slag interference. Low amperage requirement makes it excellent for poor fit-up application and on low open circuit voltage welding machines.

### APPLICATIONS:

Excellent for maintenance applications where poor fit-up is encountered. Good arc stability at low amperage also makes it excellent for applications involving light gauge steel. Welds are easily made on steel beams and girders that have many coats of paint without developing porosity or defective welds. Excellent for making repairs on machines and equipment that are covered with grease and sand and cannot be cleaned before welding. Designed for machine automotive repair, pipe line welding, tank fabrication, as well as general construction and fabrication.

### TECHNICAL DATA:

Tensile Strength.....	up to 72,000 psi (496 N/mm <sup>2</sup> )		
Yield Strength.....	up to 67,000 psi (462 N/mm <sup>2</sup> )		
Elongation %.....	approx. 25		
Current.....	AC or DC either polarity		
Amperage	50-100	70-140	90-175
(in.)	3/32	1/8	5/32
(mm.)	2.5	3.25	4.0

### PROCEDURE:

Clean weld area as much as practical. Use lower end of amperage range if an edge build-up is required or thin steel is being welded. Use high end of amperage range if the weld area is extremely dirty or if heavy penetration is required. A close to medium arc should be maintained. Slag removal is recommended but not necessary between passes.

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