

# quad alloy

QUALITY ENGINEERED ALLOYS

## QUADSTEEL 94

- Low Heat
- Excellent Out of Position
- Welds Galvanized Steel
- Welds Over Oil and Grease
- Deep Penetration
- Porosity Free
- Pass on Pass Over Slag

### DESCRIPTION

Quadsteel 94 is used for joining mild and medium carbon steels where a low heat, deep penetrating electrode is called for. The specially developed flux coating allows for all position welding even in the worst circumstances of rust, oil and grease, thus reducing costly preparation time. In addition, Quadsteel 94 may be used in the downhill mode without the common metal-slag drip common to similar electrodes. Slag removal is easy with chipping hammer or air tool. Quadsteel is used for general welding of all structural steels and mild steel pipe without slag interference. In addition, Quadsteel 94 successfully produces high strength, non-porous welds on heavily oxidized steels in tight corners and overhead.

### PROCEDURES

Clean and bevel where needed. Hold electrode at a slight incline (60°) from base metal. For vertical welds reduce amperage to suit thickness and rod diameter. Weld from bottom-up and weave, do not whip.

### TECHNICAL DATA

Tensile Strength: 83,000 psi  
Elongation: 30% (2" Bar)  
Current: AC/DC (DCEP) +/- 25%

### AVAILABILITY

3/32", 1/8", 5/32", 3/16", 1/4"