



WELTRODE WC 2100 AC-DC

MOISTURE RESISTANT LOW HYDROGEN TYPE COATED ELECTRODE FOR LOW ALLOY STEELS

WHY DO WELDERS CHOOSE WELTRODE WC 2100 AC/DC

Weltrode WC 2100 is low-hydrogen type coated electrode designed to weld all mild low-carbon and certain low-alloy steels, providing weld deposits of x-ray quality. Weld metal represents ideal combination of tensile strength, ductility and impact strength.

SPECIAL FEATURES

- ✚ Flexible flux coating allows bending of electrode for difficult positions in maintenance welding.
- ✚ Excellent restrike characteristic enables even an unskilled welder to weld repair without sticking.
- ✚ Extremely smooth - spatter and turbulence free arc transfer.
- ✚ All position welding possible. Ideal for overhead and vertical down position welding.
- ✚ Can weld galvanised steels and also operates in submerged conditions



APPLICATIONS

Excellent for joining boiler plates, pipe steel, ship building steels and cast steels.

Weld all construction steels in form of angles, channels, "T", "I" and "H" sections, particularly weathering steel and steels designed for outdoor service. Weld free machining steels, steels to be subsequently chromium plated or joints under high restraint, such as very thick sections or circumferential design.

For overlaying shafts and other worn parts when very high weld metal density is required.

TYPICAL PROPERTIES

TENSILE STRENGTH	84,000 PSI
YIELD STRENGTH	69,000 PSI
ELONGATION	32%

INTERNATIONAL SPECIFICATION

AWS/ASME IIC SFA 5.1 E7018

DIN 1913 E51 54B (R) 10

ISO 2560 E51 5B110 24H



RECOMMENDED AMPERAGE SETTINGS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	65	100	140
Maximum Amperage	100	140	190

WELDING TECHNIQUES

Clean surface and deposit electrode holding a close-to-medium arc gap. Use stringer bead or moderate weave technique and back-whip all craters. Remove slag between passes with wire brush.

Horizontal fillets can be touch welded by raising the amperage approximately by 10%.

Use any constant current AC transformer or DC generator/rectifier providing a minimum of 65 volts open circuit.

Use DC Reverse (+).