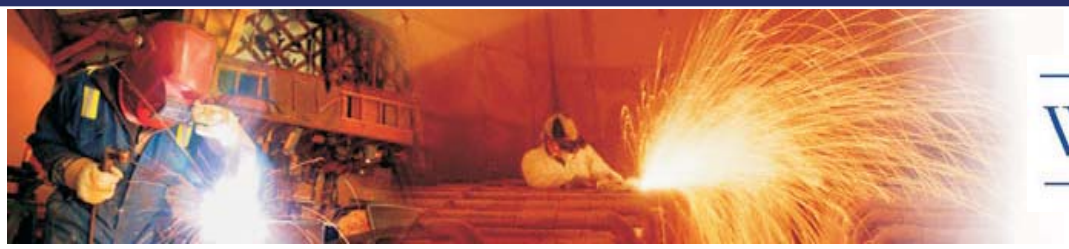

Weltrode WC 6200 Gold AC-DC

Premium High Tensile Electrode For Welding Dissimilar Steel Combinations With Unmatched Crack Resistance

Why Do Welders Choose Weltrode WC 6200 Gold AC/DC

Weltrode WC 6200 Gold is the most advanced development with Proprietory Modifications in its category of electrodes .
Improved arc stability, superior crack resistance , easy slag release , unmatched tensile strength has made Weltrode WC 6200 Gold the first choice for all steel applications with superior weld performance .

Special Features

- One Versatile Electrode for Welding Dissimilar Steels of varying compositions
- High Resistance to Underbead Cracking , Hot Cracking and Stress Corrosion Cracking
- Unmatched corrosion and heat resistance
- Controlled Ferrite content in an Austenitic mix prevents cracking.
- Superior flux chemistry of Weltrode WC 6200 Gold provides for a total and highly effective flushing away of surface contaminants such as oil, grease, rust etc to give most reliable welds in these conditions

WELTRODE®
The Welding Technology

- Welds from Weltrode WC 6200 Gold ensures practically less distortion warpage and stress.
- Superior Resistance to Shock and impact

Applications

For joining and building up of all kinds of steels including

Medium- Carbon Steel, High-Carbon Steel, Heat-resistant Steel, Spring Steel , Shock-resistant Steel, Vanadium Moly Steel, Chrome Steel, Hardened Steel, Manganese Steel, T-1 Steel, Quick Speed Steel, Cast Steel , Sulfur Bearing Steel , All Stainless Steels , Tool Steels

and all unidentified Steels

Heat Treatment Baskets , Gear Teeth , Chain links , Drives and Sprockets , Crane Rails and Brooms Leaf Springs are few of applications

Typical Properties

Tensile Strength	
As Welded	130,000 Psi
As Work Hardened	195,000 Psi
Hardness	Brinell 320
Yield Strength	91,000 Psi
Elongation	35%

WELTRODE®
The Welding Technology

International Specification

AWS/ASME IIC A 5.4 E312-17

DIN 8556 E29.9 R 23

ISO 3581 E29.9 R 23

Recommended Amperage Settings

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)
Minimum Amperage	25	35	50
Maximum Amperage	45	65	80

Welding Techniques

Clean weld area. The area in which weld is to be made should be free of rust, grease, paint and other material which cause weld contamination. Bevel heavy sections to be joined. Preheat high alloy and high carbon steels to that required by base metal. Adjust amperage within recommended range and deposit electrode, maintaining a short to medium arc length. Tilt the electrode 15 degrees in the direction of travel. Raise amperage slightly and drag weld inclining the electrode 45 degrees in the direction of travel for rapid filleting. Back-whip craters and remove slag between passes where ever possible. Peening to release stresses in beneficial.

Use any constant current AC transformer or DC generator/rectifier providing a minimum of 55 volts open circuit.

DC reverse polarity (Electrode +) or AC.