Weltrode WC 6150 AC-DC

High Tensile Strength Electrode For Joining All And Any Steel In Existence Including Unknown Steels

Why Do Welders Choose Weltrode WC 6150 AC/DC

Weltrode WC 6150 Is An All Position AC/DC Coated Electrode, Depositing High Alloy Weld Metal, Designed To Produce Crack-Free Deposits, Having Very High Mechanical Properties. Superior Performance On Limited Output AC Welding Machines.

Special Features

- The Unique Coating And Special Alloy Core Wire Produces A Homogeneous, Porosity Free Machinable Weld Deposit.
- The High Tensile Strength Of Weltrode WC 6150 Increase In Use Due To Its Work Hardening Qualities Giving The Most Reliable Welds.
- Controlled Penetration Provides Optimum Strength And Gives Best Results On Any
- Steels. Controlled “Silion” Content Prevents Cracking. The Unique Composition Of

  Weltrode WC
  6150 Neutralises The Harmful Effects Of Carbon Pickup Or Dilution In Weld Metal Thus
- Eliminating Sidebead Cracking And Underbead Cracking.

  Pass On Pass Welding Without Slag Removal Possible Without Slag Entrapment.

WELTRODE®
The Welding Technology

- The Controlled Arc Drive And Fluidity Of Weltrode WC 6150 Enables It To Perform Well In Dirty Contaminated And Oil Saturated Weld Zones Thus Eliminating The Need To Carry
  The Necessary Preweld Operations And Saving Downtime.
- High Corrosion And Heat Resistance.
- Shock And Impact Resistance Equivalent To Manganese Alloy Steels And Other Steels Designed For Impact Applications.

Applications

Weld All Carbon And Alloy Steels - Low - Medium - High In All Positions, Under All Conditions, Including Dissimilar Combinations.

Weld All Tools Steels, Manganese Steels And Speciality Steels In Thick To Thin Designs.

Drag Or Touch Welding Technique May Be Used, Particularly In Fillets Without Slag

Interference. Successful Welds On Hot And Cold Shears, Drill Shanks, Springs, Drill

Shank Extensions, Tap
Extraction, And Heat Treat Baskets.

Typical Properties

Tensile Strength

As Welded	**110,000 Psi**
As Work Hardened	**175,000 Psi**
Hardness	**Brinell 280**
Elongation	**26%**

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The Welding Technology

International Specification

Proprietory Modification

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	35	60	75
Maximum Amperage	70	110	140

Welding Techniques

Clean Surface. Bevel Heavy Sections To Be Joined. Adust 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 Wherever Possible. On High Tool Steels It Is Advisable To Preheat According To Base Metal To Obtain Best Results.

Use Any Constant Current AC Transformer Or DC Generator/Rectifier Provided A Minimum Of 55 Volts Open Circuit

DC Reverse Polarity (Electrode +) Or
AC.