



Weltode WC 6000 AC-DC

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

Why Do Welders Choose Weltrode WC 6000 AC/DC

Weltrode WC 6000 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 6000 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 6000 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.



- ✦ The controlled arc drive and fluidity of Weltrade WC 6000 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	116,000 Psi
As Work Hardened	180,000 Psi

Hardness	Brinell 320
Yield Strength	87,000 Psi
Elongation	32%



International Specification

AWS/ASME IIC SFA 5.4 E312-16

DIN 8556 E29.9 R 23

ISO 3581 E29.9 R 23

BS 2926 - 1984 29.9R

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. 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 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.