



TEXAS \* PENNSYLVANIA \* NORTH CAROLINA  
<http://hi-alloy.com>

## HI-ALLOY MARVEL WELD

### UNIVERSAL ELECTRODE FOR MILD STEEL

**DESCRIPTION:** Simply marvelous is the best way to describe this electrode. With sizes from 1/16" through 3/16", amperage ranges from 20 through 220 amps, all position, any polarity capabilities, and the ability to weld through galvanizing, water, grease, oil, paint, and rust what else could it be called but Marvel Weld. You can even bend this electrode and keep it in contact with the base metal to weld in the most awkward and precarious of situations.

**TYPICAL APPLICATIONS:** Welding of sheet metal, plates, pipes, beams, angle iron, galvanized steel, plug welding, spot welding, tacking and general fabrication.

**PROCEDURES:** For best results, clean the base metal in accordance with good welding practice, use AC polarity for thin metals, DC Straight or DC Reverse for thicker metals, use a short to medium arc length for general welding and lean the electrode toward the direction of travel, use stringer beads or a slight weave technique.

**SIZES AVAILABLE:** 1/16 5/64 3/32 1/8 5/32 3/16

**AMPERAGE RANGES:** 20-40 30-50 50-70 70-110 115-140 150-220

**POLARITY:** AC, DC Straight, or DC Reverse

**TENSILE STRENGTH:** Up to 82,000 psi

**YIELD STRENGTH:** Up to 70,000 psi

**ELONGATION:** Up to 25%