



# HI-ALLOY STEELBOND 1

## ALL POSITION GENERAL PURPOSE STEEL ELECTRODE

**DESCRIPTION:** Steelbond 1 is ideally suited for difficult maintenance repairs. It excels at welding on carbon steels under the most adverse conditions. Its forceful arc can penetrate rust, grease, dirt, paint, and galvanizing. Steelbond 1 can also be used to weld poor fitting joints because of its ability to bridge gaps up to 3/8 of an inch. This electrode can even be bent without the flux chipping to help reach those hard to access areas.

**TYPICAL APPLICATIONS:** Poor fit-up joints, pipe welding, dirty or rusty steels, tack welding, general maintenance on carbon steels.

**PROCEDURES:** Clean the base metal in accordance with good welding practice if circumstances allow, weld with a short to medium arc length at low amperage. When surface preparation is not feasible, select the higher amperage range and use a medium to long arc length.

AVAILABLE SIZES:	3/32	1/8	5/32
AMPERAGE RANGES:	25 - 75	35 - 125	50 - 160
POLARITY:	DC Reverse, DC Straight, or AC		
TENSILE STRENGTH:	Up to 80,000 psi		
YIELD STRENGTH:	Up to 68,000 psi		
ELONGATION:	Up to 24%		