FUSION™ UNIVERSAL E

Stick Electrode for Welding a Wide Range of Steels

FUSION™ UNIVERSAL E is a stick electrode that can be used for fabrication joining welds, repair, and maintenance on a wide range of steels. It repairs jobs where high strength and toughness are required. General hardfacing applications is used where impact resistance and work hardening is required. It is best to buffer the layer before hardfacing with high hardness material. UNIVERSAL E has exceptional corrosion resistance, cavitation and impact. Depending on the amount of impact, the weld deposit work hardens to different degrees. This product has excellent crack resistance. Weld deposit displays exceptionally high ductility and elongation.

Typical Deposit Characteristics

Abrasion Resistance	Moderate
Impact Resistance	Excellent
Hardness	
As Welded	150 – 200 HB
Work Hardened	47 – 50 HRC
Tensile Strength	101,000 PSI (690 MPa)
Yield Strength	76,000 PSI (510 MPa)
Elongation	40%

Operational Characteristics / Welding Parameters

Diameter	3/16” (4.8)	OR	5/32” (4.0)
Current, A	130 – 200	OR	120 - 150
Position	All		

TYPICAL ALL-WELD METAL ANALYSIS							
C	**Mn**	**Si**	**Cr**	**Ni**	**Mo**	**S**	**P**
0.12	4.7	0.5	19.0	9.0	1.00	0.01	0.02

Typical Applications

- Fabrication, repair, and maintenance on a variety of steel.
- Restore jobs where high strength and toughness are required.
- General hardfacing applications where impact resistance and work hardening is mandatory.

Standard Sizes & Packaging

Diameter: 3/16” (4.8) OR 5/32” (4.0)
Packaging: 10 lbs.

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