



Maintenance & Repair Electrode  
for Contaminated Steels

# SteelTectic N<sup>®</sup>



- Welds on steels that are rusty, dirty or heavily scaled
- Easily controlled for continuous welding
- Can be used over a wide amperage range
- Excellent for poor or irregular fit-ups

# SteelTectic® N

SteelTectic N is an all-position electrode recommended for welding dirty, rusty, contaminated and heavily mill-scaled steels. The deeply penetrating arc effectively cuts through surface contamination and provides a sound weld.

SteelTectic N will provide a solid weld base on “dirty” parts where a more sensitive electrode can be used to complete the weld. The arc is easily controlled which aids in non-stop welding. Poor fit-up assemblies can be easily repaired at lower amperages. SteelTectic N can be used on mild and plain carbon steels.

## TECHNICAL DATA

Typical Values	
Tensile Strength:	70,000 psi (482 MPa)
Yield Strength:	61,000 psi (420 MPa)
Elongation:	22%
Current & Polarity:	AC or DCEP (+)

### SUGGESTED WELDING PARAMETERS:

Diameter	Amperage
3/32" (2.4mm)	40 - 70
1/8" (3.2mm)	30 - 140
5/32 (4.0mm)	50 - 175

## PROCEDURE FOR USE

**PREPARATION:** Remove excessive scale. Weld joints typically do not need to be beveled. Preheating is generally not required on mild and plain steels, however is recommended to drive off moisture, for parts over 1" thick or highly restrained joints.

**TECHNIQUE:** A “contact technique” is recommended for fillet welding and a reasonably small arc-gap is recommended for flat, bead-on-plate welding. Deposit using stringers or by weaving (2x - 3x). Weaving more than 3x the electrode diameter is not recommended in order to avoid slag inclusions.

**POST-WELDING:** Slow cool parts in still air.

## TYPICAL APPLICATIONS

- Machine Guards
- Farming Equipment
- Galvanized Parts
- Painted Tanks
- Oil-Contaminated Steel Housings
- Steel Housings

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 “Safety in Welding and Cutting and Allied Process”. Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



**Eutectic Corporation:**  
N94 W14355 Garwin Mace Dr.  
Menomonee Falls WI, 53051 USA  
+1 800. 558. 8524 • eutectic.com

**Eutectic Canada:**  
428, rue Aimé-Vincent, Vaudreuil-Dorion,  
Québec J7V 5V5 Canada  
+1 800. 361. 9439 • eutectic.ca



Follow Us On...

