



Stud-Xtract

AC/DC+

ALLOY STEEL

DESCRIPTION

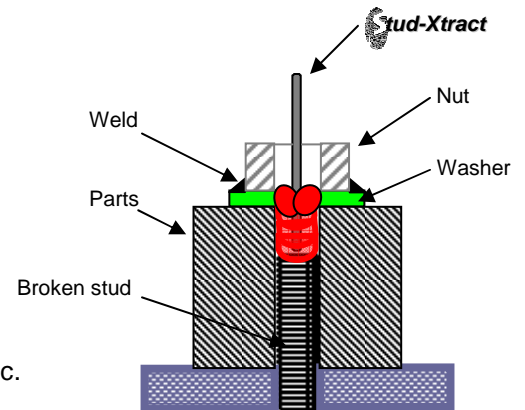
Specially engineered flux coated electrode that protects the threads during the welding process. Designed to remove broken studs, bolts, taps, drill bits, screw extractors, etc

CHARACTERISTICS

- **EZ-STRIKETIP** graphite striking tip
- Can also be used in horizontal position
- Easy striking and re-striking
- Can be used with all grades of bolts
- High mechanical properties (125 000 psi)
- Saves times and money
- Low amperage and easy to use

TYPICAL APPLICATIONS

All broken studs, bolts, taps, drill bits, screw extractors, etc.



PROCEDURE

- 1 - Get a nut and a washer
- 2 - Choose a diameter of **Stud-Xtract** rod and set your welding machine to the recommended amperage
- 3 - Put the electrode perpendicular on the center of the bolt and strike the arc
- 4 - Build up stud until it sticks about 3 mm (1/8") over the casting. Do not direct the arc in the direction of the threads. Keep the electrode perpendicular and in the center of the hole to be filled.
- 5 - Weld washer to stud build-up deposit.
- 6 - Weld the nut to the washer and unscrew nut to remove stud

MECHANICAL PROPERTIES

Tensile strength: 125 000 psi (860 MPa)
Elongation: 30 - 35%

WELDING PARAMETERS

Diameter:	3.2 mm (1/8")	2.5 mm (3/32")	2.0 mm (5/64")
Amperage:	90 – 110 A	60 - 80 A	35 - 55 A

Packaging: 0.5 Kg

Rév. : 7_01

Specialized welding alloys and technology. For technical assistance or for ordering: