

Tartan[®] AAA

Shielded Metal Arc Welding (SMAW – Stick)

For mild to medium grade carbon steels, all positions.

Features

- 86,000 psi Strength
- 28% Elongation
- Micro-Dense Moisture Resistance Coating
- Triple Deoxidized Deposit
- Low Spatter
- Excellent Out Of Position
- Ideal Under Worst Conditions
- Ultimate Puddle Visibility
- Runs Vertical Down
- Pass On Pass Over Slag

Characteristics

Tartan AAA is ideal for mild to medium grade carbon steels under the most challenging conditions. Triple deoxidizing deposits enable **Tartan AAA** to leave sound welds even when the base metal is contaminated with paint, rust, grease, or other contaminants. With a moisture resistant flux, **Tartan AAA** can create beautiful beads and welds in wet conditions or even through flowing water.

Tartan AAA is the ultimate service truck rod and a high performing alternative to 6010 or 6011. This durable rod can be bent to weld around corners, holds a stable arc even when the rod itself is wet, and can be used in all positions, including overhead.

Excellent for use on farms, service trucks, city shops, marine settings, or anywhere you find yourself doing maintenance work or repairs on dirty contaminated steel.

Technical

Size and Amps AC/DC ±50%

Inches	1/16	3/32	1/8	5/32
(mm)	(1.6)	(2.4)	(3.2)	(4.0)
Amps	30	50	100	120

With DC use reverse polarity. (DCEP)

Application

- **Tartan AAA** can be used as contact or short to medium arc.
- Tilt 15° to 20° in direction of travel.
- Metals should be cleaned when possible.
- Can be used vertical up using weave or vertical down with stringers.

Tartan® A

Shielded Metal Arc Welding (SMAW – Stick)

For mild and low alloy steels.

Features

- Ultra Low Spatter
- 80,000psi Strength
- Easy Slag Removal
- Contact Electrode, Easy To Use
- Ideal Buzz Box Electrode
- Exceptional Out Of Position

Characteristics

Tartan A is an ideal electrode for general mild and low alloy steel applications. It has been specially developed for the maintenance welder. **Tartan A** runs with ease in all positions producing a sound weld deposit with minimum operator skill. Stringer or weave beads may be used with equal success. Vertical welds are simple either up or down.

Tartan A has a wide range of amperage settings which make it easy use on thin, thick or poor fit-up applications. **Tartan A** exhibits excellent crack resistance with low alloy steels. Deposits exhibit excellent machinability.

Technical

Size and Amps AC/DC ±50%

Inches	1/16	3/32	1/8	5/32
(mm)	(1.6)	(2.4)	(3.2)	(4.0)
Amps	25	50	80	100

With DC use reverse polarity. (DCEP)

Application

- Hold electrode at a slight incline in the direction of travel.
- For vertical or overhead welds lower amperage setting, weave and move fast enough to prevent weld puddle from dropping.

Tartan® B

Shielded Metal Arc Welding (SMAW – Stick)

For mild and low alloy steels.

Features

- Welds Over Dirt and Oil
- 80,000psi Strength
- Deep Penetration
- Great On Galvanized Steel
- Easy Vertical and Overhead
- Wide Range Of Amperage

Characteristics

Tartan B provides deep penetration deposits without slag interference. In maintenance or production welding, the characteristics of **Tartan B** enable the welder to produce high strength non-porous welds on pipe in tight corners and overhead. These results are possible even when welding over paint, rust and dirt. Can be run pass on pass over slag. Tartan B is a superior replacement to standard 6011.

Technical

Size and Amps AC/DC ±50%

Inches	3/32	1/8	5/32	3/16
(mm)	(2.4)	(3.2)	(4.0)	(4.8)
Amps	50	80	100	150

With DC use reverse polarity. (DCEP)

Application

- Hold electrode at a slight incline in the direction of travel.
- For vertical or overhead welds lower amperage setting, weave and move fast enough to prevent weld puddle from dropping.
- When welding on galvanized steel we recommend using **Galv Coat**, our premium zinc spray, for after weld coatings. (For more info see Chemical Aids in the Abrasives & Metal Working products section.)