

# **ProCus 686**

**AN ELECTRODE FORMULATED TO  
WELD A WIDE RANGE OF CARBON  
STEELS AND EXHIBITS SMOOTH  
WELDING CHARACTERISTICS**

**ProCus 686 IS FORMULATED TO BE EASY TO USE.  
ALSO, ITS SPECIAL FORMULA ENABLES THE  
ELECTRODES TO BE USED TO WELD HIGHER  
STRENGTH STEELS**

## **SPECIAL FEATURES:**

**ProCus**

- For welding higher strength steels
- Superb for those difficult maintenance applications
- Special “twin” flux coating enables easy of application
- Outstanding strike, re-strike characteristics
- Great for out of position welding

**686**

**PROCUS 686 – AN ELECTRODE THAT IS A MUST  
USE FOR MAINTENANCE WELDING**

**PROCUS – PROduct excellence – CUStomer service**

# ProCus 686<sub>AC-DC</sub>

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## TECHNICAL INFORMATION

### DESCRIPTION

ProCus 686- an electrode alloyed to weld the higher strength steels often encountered in maintenance while exhibiting easy welding characteristics.

### FEATURES

Persons who work in maintenance are often confronted with difficult repair applications. Often these repairs require welding of the higher strength steels that may be dirty or rusty and which may be located in areas of poor accessibility. Normally, the types of electrodes used for these applications have poor arc characteristics, difficult to remove flux deposits and are, in a general sense, difficult to use so an electrode that simplifies welding in these situations must provide time and cost benefits.

ProCus 686 is such a product. For an electrode designed to weld the higher strength steels it exhibits exceptionally smooth running characteristics. A significant feature of the electrode is its special twin flux coating. While the coating type contributes to the good arc qualities of the electrode, it also provides for its easy removal after welding.

The special formula of the flux coating provides for all positional welding qualities. The electrode's strike, re-strike features make it easy to use, particularly in those areas of poor accessibility. Arc transfer is quiet and deposits exhibit little or no spatter.

The weld metal transfer of ProCus 686 is smooth and so provides an excellent wash of the molten metal to reduce or eliminate in incidence of undercutting. This is extremely important for when high quality welds are necessary.

### TECHNICAL DATA

Tensile strength: Up to 520 MPa

Shear strength: Up to 440 MPa