



4500 Gateway Blvd. * Springfield, Ohio 45502 * Phone (937) 325-9900 * Fax (937) 325-2046
 4847 Peavey Drive * Meridian, Mississippi 39301 * Phone (601)482-0432 * Fax (601) 482-0465

WELDING ROD COMPATIBILITY BULLETIN

THE FOLLOWING WELDING RODS HAVE BEEN DETERMINED TO BE COMPATIBLE WITH THE TEIKURO PROCESS

Manufacturer	Welding Rod	Hardness	% Nickel	% Chrome
Alloy Rods Corporation Hanover, PA 17331 800-933-7070	Arcaloy 410	38	.52%-.60%	11.8%
	Barlet Associates Warren, MI 48090 313-779-1680	Appache CM-2 Appache HW-2 Appache HW-4 Appache HW-45 Appache XPT-16	40-42 54-56 57-58 45 45-46	0.08% 0% 0% 0% 0%
Certanium Alloys Cleveland, OH 44103 216-391-8300	No. 15a	60	0%	5-10%
	No. 210	30-40	5-10%	1-5%
	No. 219a	55-60	0%	1-5%
	No. 702	60-62	0%	0%
	No. 705a	20	1-5%	.10-1%
Cronatron Welding Systems Charlotte, NC 28216-2367 1(704) 598-1225	No. 889	20	40-60%	0%
	Cronaweld 340	30-35	4%	12.00%
	Cronatig 340T Cronatig 340M	30-35 30-35	4% 4%	12.00% 12.00%
Eureka Welding Alloys 2000 E. Avis Drive Madison Heights, MI 48071 248-588-0001	EXP-10	36-40	10.5%	5%
	Nickel 60 *	<20	55%	0%
	No. 72 HWTS	53-57	0%	5%
	No. 74	56-60	0%	3.50%
	No. 130-A	30-40	0%	1%
	No. 350	36-40	10% MAX	11%
	No. 500	20 MAX	15% MAX	29%
	No. 515 Ultra	20 MAX	9%	29%
	No. 1215	56-60	0%	5%
	No. 1216	61-64	0%	4.50%

* Typical hardness and percent nickel values were tested by the welding rod manufacturer

Teikuro Corporation does not recommend any specific welding rod. The above listed rods have been tested by our laboratory and found to be compatible with the Teikuro Process. Should you have a question about any other rod, please submit samples to our laboratory in Springfield, Ohio for evaluation.



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Manufacturer	Welding Rod	Hardness	% Nickel	% Chrome
Eutectic Corp. Flushing, NY 11358 800-323-4845 718-358-4000	Endotec DO*23	<20	59-60%	0%
	Eutectrode 27	30	0%	0%
	Eutectrode 66	<20	0.05%	0.03%
	Eutectrode XHD6804	50	0.40%	13%
	Tig – Tectic 5 AH	53-61	0%	5.2%
	Tig- Tectic 5 HSS	62	0%	39%
	Xuper 680 CGS	36-40	9.50%	29%
	Xuper 22*33N	<20	55.00%	0%
	Tig-Tectic 5 OH	47-50	0.00%	1%
	Tig-Tectic 680	24	9.00%	30%
	Tig-Tectic 66	82(B)	0.00%	0%
	Tig-Tectic 45301W	45	0.00%	2%
	Lincoln Electric Company Cleveland, OH 44117 216-481-8100	E6013	<20	0%
E7018		<20	0%	0.20%
M&R Welding Alloys Pittsburgh, PA 15230 412-682-5510	M&R 177	50-54	10%	5%
	M&R 209	38-42	17%	5%
MPD Welding Inc Troy, MI 48099-9277 1(800)266-Weld	MPD 110	35-38	0%-8%	5%
	MPD 162	N/A	0%	3.75-4.5%
	MPD D6510	54-57	0%-8%	0 – 10%
McKay Welding Products Troy, OH 45373 937-332-5706	Cast Alloy T-60	N/A	46%	
	GP	N/A	9%	
	Hardalloy 58	45-60	0%	
	Hardalloy 61	53-63	0%	

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Manufacturer	Welding Rod	Hardness	% Nickel	% Chrome
MG Industries Menomonee Falls, WI 53051 414-255-5520	MG 210	<20	57.00%	0%
	MG 460(zinrepair)	<20	0%	0%
	MG 540	32	0.04%	0.03%
	MG 600	23-30	9.25%	29.10%
	MG 700	58-62	0%	4%
	MG 710 (tig)	55-60	0%	8%-9%
	MG 760	55-60	0%	8%-9%
Misumi USA, Inc Itasca, IL 60143 708-773-3244	EA600W	56-62	0%	9.10%
	GRICAST 31	<20	55.30%	0%
	MH-1	56-60	0%	0%
	MH-2S	50	0%	0%
	SF-3	36-40	6.00%	5.20%
Thermocote Welco Kings Mountain, NC 28086 704-739-6421	3-FH	FH up to 45	0%	0.98%
	310-316	35	20-23	25%-28%
Tokai Yogyo Co. Ltd. Nagoya, Japan	NCF-12	30	9.50%	N/A
	TC-3A	<20	56.18%	0%
Tokai Yogyo Co. Ltd Nagoya, Japan	T11-CR	40-50	12%	11.05%
	TM2000	45.3	10.91%	4.92%
	TM2000B	37-39	10.92%	4.87%
	TS-12	30	9%	30.68%
Tokuden Co., Ltd. Fujisawa, Japan	H11-Cr	40-50	12%	11.05%

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Manufacturer	Welding Rod	Hardness	% Nickel	% Chrome
Vulcan Systems, Inc. Fenton, MI 48430 800-241-9885	400-HC	25-30	7%-10%	26% - 34%
	T-400-HC	25-30	7%-10%	26% - 34%
	450-DD	45-49	15%-30%	0%
	500-CI	30-36	52.17%	0%
	T-500-CI	30-36	52.17%	0%
	910-AH	56-59	N/A	5%
	930-HS	60-63	0%	3.75% - 4.5%
	T-930-HS	60-63	0%	3.75% - 4.5%
	940-HW	54-57	0%	4.75% - 5.5%
	T-940-HW	54-57	0%	4.75% - 5.5%
	9030-HS	60-62		
	SUN-ARC	25-30	8%-10.5%	28%-32%
	MS999HW	58	0%	4.70%
	Weld Mold Company Brighton, MI 48116 810-229-9521	Polymatic 705FC	34-36	7.5%-9%
Polyweld 747-L		46-48	8%	4.0%
535		35-38	2.53%	1.73%
700		20	25.7%	
705		40	5.0%	2.2%
750		34	10.4%	0.4%
808-HD		34-35	8%-10.5%	28%-32%
880		20	5.3%	12.8%
943-L		54-57	0%	0.00%
943-FC		54-57	0%	4.10%
954		38-42	0%	4.10%
954-T		30-32	0.60%	4.6%-6.0%
958-T		52-54	0%	4.85%-5.35%
9770-T		30-32	17%-19%	0.00%
Weldtech International Cincinnati, OH 45215 1(513)772-5005	CI - 10 (M&R 209)	36-40	10% - 11%	5.5% - 6.5%
X-Ergon Partsmaster Irving, TX 75285-5326 1(800)527-9916	Cor-Therm #186	45	11% Max	35% Max

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**WELDING ROD INCOMPATIBILITY BULLETIN
WARNING!!**

**THE FOLLOWING WELDING RODS HAVE BEEN DETERMINED TO BE
INCOMPATIBLE WITH THE TEIKURO PROCESS**

Manufacturer	Welding Rod	Reason for
<p>Cronitex – Metallurgie SchwelBtechnik GmbH 51467 Bergisch Gladbach Zum Scheider Feld 18 Germany</p>	<p>Croni-WIG GG-TEC Croni-MIG GG-TEC</p>	<p>High Nickel – 65%</p>
<p>Eureka Welding Alloys Madison Heights, MI 48071 248-588-0001</p>	<p>Eureka 99Ni</p>	<p>High Nickel – 99%</p>
<p>Eutectic Corporation Flushing, NY 11358 800-323-4845</p>	<p>Castec 3099 Eutectrode N9080 XHD 6899 Xuper 22*24N Xuper 2222XHD Xyron 2-24</p>	<p>High Nickel – 92% High Nickel – 63% High Nickel – 70% High Nickel – 92% High Nickel – 70% High Nickel – 92%</p>
<p>MG Industries Menomonee, WI 53051 414-255-5520</p>	<p>MG 470</p>	<p>High Aluminum – 85 – 95%</p>
<p>Misumi USA, Inc. Itasca, IL 60143 708-773-3244</p>	<p>CIA -1</p>	<p>High Nickel – 96%</p>
<p>Tokai Yogyo Co., Ltd. Nagoya, Japan</p>	<p>TC – 1</p>	<p>High Nickel – 99%</p>
<p>Vulcan Systems Fenton, MI 48430 800-241-9885</p>	<p>Vulcan T-400CG</p>	<p>Too Soft – For Underlayment Only</p>