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# EZ PACK - 0.5 kg

**STEEL / ALLOY STEEL  
BRONZE / ALUMINUM  
STAINLESS STEEL**



**HARDFACING  
CUTTING - PIERCING -  
CHAMFERING / CAST IRON**

# SUMMARY & EQUIVALENCES

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Formerly EZWELD-GO

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Formerly EZWELD-ALU

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# **Soudotec 222 SP**

**STEEL**

**High quality** electrode with a specially designed coating for welding mild steels and specifically **galvanized steels**.

Tensile strength : 80 000 psi (550 MPa)

Yield strength : 64 000 psi (440 MPa)

Elongation : 24 - 28 %

## The product :

- All-position welding, including vertical down
- Excellent on AC power supply, low amperage
- Ideal for thin sheets
- Flexible moisture-resistant coating
- Easy striking and re-striking (OCV = 45 V); ideal for tack welds

## APPLICATIONS

Recommended for steel furniture, thin sheet metal, farm machinery, body work, and specifically for galvanized steel.

## PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec G12** electrode. Maintain a short arc. Remove slag between each pass.

Ø mm - (pouce)	AMPÉRAGE (A)
1.6 - (1/16)	30 - 45
2.0 - (5/64)	40 - 60
2.5 - (3/32)	70 - 90



Exceptional **high-strength** electrode for welding high carbon and high alloy steels. Highly recommended for welding all types of unknown steels between themselves or as dissimilar assemblies. Excellent as a cushion before hardfacing on high alloy steel.

Tensile strength : 120 000 psi (827 MPa)  
Yield strength : 100 000 psi (690 MPa)  
Hardness : 21 HRC  
Elongation : 28 - 32 %

### The product :

- Excellent mechanical properties
- Very good weldability in position
- Machinable, crack-free deposit
- Corrosion, heat and oxidation resistance

### APPLICATIONS

Repair of spring blades, drill bits, molds, dies, chains, mechanical shovel parts, crane booms, axles, shafts, tool steels, cast steels, armour steels, etc.

### PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec G12** electrode. Maintain a short arc. Remove slag between each pass.

Ø mm - (inch)	AMPERAGE (A)
2.5 - (3/32)	60 - 75



Exceptional electrode with **superior blowing capacity** for gouging, cutting and piercing almost any metal such as carbon steels, low alloy steels, stainless steels, cast iron, copper and aluminum.

### The product :

- Does not require any compressed air
- Excellent performance on AC power supply
- Easy striking and restriking
- Easy-to-use electrode
- No slag adherence to base metal

### APPLICATIONS

Ideal for gouging weld beads, cast irons, stainless steels and almost any other metal. Excellent for piercing and cutting.

### PROCEDURE

Place electrode tip on metal and push rapidly back and forth in a sawing motion while holding almost flat (20°) and in direct contact with the work-piece. For deeper grooves, repeat the procedure.

Ø mm - (inch)	AMPERAGE (A)
2.5 - (3/32)	120 - 225



All-position **economical hardfacing** electrode for hardfacing carbon steels, low-alloy steels, cast steels and manganese steels subjected to **abrasion, moderate impacts, and metal-to-metal friction**.

Hardness (as-welded) : 55 - 60 HRC

## The product :

- Excellent all-position weldability, even on AC power supply
- Crack-free deposit
- Smooth arc and low spatter
- Dense and porosity-free deposits
- Easy slag removal

## APPLICATIONS

Crusher jaws, plow blades, excavation equipment, pulleys, guides and transport rails, chisels, scrapers, bucket teeth, etc.

## PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. Remove damaged metal with **Soudotec G12**. Keep a short arc with the electrode slightly inclined. Remove slag between passes. If more than three passes are required, use **Soudotec 340** or **Soudotec 342** as a cushion.

Ø mm - (inch)	AMPERAGE (A)
3.2 - (1/8)	110 - 135



# Selectarc 416

STAINLESS  
STEEL

**Very high-recovery (175%)** 316L «JET» type electrode for welding and building up Cr-Ni-Mo stainless steels type; 316, 316L, 317, 317L and 318.

Tensile strength : 90 000 psi (620 MPa)

Yield strength : 68 200 psi (470 MPa)

Elongation : 40 %

## The product + :

- Excellent corrosion and heat resistance
- Easy slag removal
- Easy striking and restriking; the electrode will not overheat
- Ideal on thin sheets and heavy sections
- Very high deposit rate

## APPLICATIONS

Recommended for food and dairy industries, slaughterhouses, bottling machinery, hospital equipment, paper mills, chemical industries, etc. Ideal for 1.6 mm (1/16") thick stainless steel sections.

## PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** or **Soudotec G12** electrode. Maintain a short arc. Remove slag between each pass. Only use perfectly dry electrodes.

Ø mm - (inch)	AMPERAGE (A)
1.6 - (1/16)	35 - 50
2.5 - (3/32)	55 - 105



**Economical** ferro-nickel type electrode (Ni 60) for joining grey, malleable, nodular and highly solicited cast iron. Recommended for welding dissimilar assemblies between **cast iron and steel**. Excellent on dirty and oily cast iron.

Tensile strength : 65 000 psi (450 MPa)

Hardness : 200 BH

## The product :

- High cracking resistance and homogeneous deposit
- Excellent anchorage of deposited metal
- All position weldability
- Hardly machinable deposit
- Conform to standard AWS A5.15 : ENiFe-CI

## APPLICATIONS

Engine blocks, agricultural equipment, high thickness parts, pump housings, foundry defaults, cast parts, etc.

## PROCEDURE

Clean surface of oil, grease and dirt. Remove cracks with **Soudotec G12** electrode. Keep a short arc. Peen each bead for stress relief. Let cool slowly.

Ø mm - (inch)	AMPERAGE (A)
2.5 - (3/32)	50 - 80
3.2 - (1/8)	90 - 110





# **Soudotec 99 BF**

**CAST  
IRON**

**Economical** pure nickel type electrode (Ni 99) for joining grey, malleable and nodular cast iron. Excellent for buttering before using a ferro-nickel type electrode. The coating is non conductive.

Tensile strength : 50 000 psi (350 MPa)

Hardness : 180 BH

## **The product** :

- Excellent machinability
- Porosity free deposit
- All position weldability
- Excellent anchorage of deposited metal
- Conforms to standard AWS A5.15 : ENi-CI

## **APPLICATIONS**

Ideal for rebuilding cast iron parts and for joining thin parts. Machinable errors, head of engine, cylinder chamber, transmission box, reducers, cast parts. Recommended for sealing joints.

## **PROCEDURE**

Clean surface of oil, grease and dirt. Remove damaged metal or chamfer cracks with the **Soudotec G12** electrode. Keep a short arc. Peen each bead for stress relief. Let cool slowly.

<b>Ø mm - (inch)</b>	<b>AMPERAGE (A)</b>
2.5 - (3/32)	50 - 80
3.2 - (1/8)	90 - 110



**High strength** flux-coated rod with **low silver content** for brazing ferrous metals and copper alloys together or as dissimilar assemblies.

Tensile strength : 100 000 psi (689 MPa)

Elongation : 25 %

Hardness : 200 BH

Bonding temperature : 760°C (1 400°F)

## The product :

- Excellent fluidity
- May replace silver alloys in certain applications
- Good adherence to cast irons, copper alloys, stainless and alloy steels
- Deposits suitable to plating

## APPLICATIONS

Dissimilar assemblies. Recommended for the repair of tempered steel parts, tools, molds (tool steel), extending drill bits, bearings, fittings, vices, bushings, etc. Do not use on aluminum and/or magnesium alloys.

## PROCEDURE

Clean the section to be brazed. Gouge the thick sections and preheat the joint. Heat to obtain a liquid flux. Melt filler metal until it flows and bonds easily with the base metal. Cool slowly. Use a neutral flame.

Ø mm - (inch)

2.5 - (3/32)



Specially designed electrode for welding and rebuilding aluminum and its various alloys.

Tensile strength : 34 000 psi (235 MPa)

Elongation : 15 - 25 %

Hardness : 40 - 60 BH

## The product :

- Porosity-free and corrosion resistant deposit
- Good color match with aluminum
- Stable arc in all positions
- Active coating especially suited for welding of contaminated aluminum
- May be used with torch
- Only use in CC+ polarity

## APPLICATIONS

Recommended for cast aluminum parts, truck bodies, transmissions, tanks, pipes, repairing machining errors, building up missing sections on castings and mouldings, extrusions, plates, etc.

## PROCEDURE

Remove the oxide layer prior to welding. Preheating of thick sections is recommended to facilitate welding. Weld while holding the electrode almost vertical while maintaining a short arc so the coating almost touches the base metal. Remove slag between each pass and cool slowly. The deposit may not be anodized.

Ø mm - (inch)	AMPERAGE (A)
2.5 - (3/32)	50 - 80
3.2 - (1/8)	70 - 120



# CHOOSE THE RIGHT ELECTRODE FOR THE RIGHT JOB

BASE METAL	ALL MILD STEELS	CAST STEELS	HARD TO WELD STEELS	UNKNOWN STEELS	DIRTY ONLY UNKNOWN CAST IRON	FOR 100% MACHINABLE CAST IRON	STAINLESS STEELS	For gouging, piercing and cutting all ferrous and non-ferrous metals with 225 AC or DC welder use Soudotec G12
ALL MILD STEELS	222	230	230	230	60	60 - 99 BF	416	
CAST STEELS	230	230	230	230	60	60 - 99 BF	416	
HARD TO WELD STEELS	230	230	230	230	60	99 BF	230	
UNKNOWN STEELS	230	230	230	230	60	99 BF	230	
DIRTY ONLY UNKNOWN CAST IRON	60	60	60	60	60	-	60	
FOR 100% MACHINABLE CAST IRON	99 BF	99 BF	60 - 99 BF	60 - 99 BF	-	99 BF	-	
STAINLESS STEELS	416	416	230	230	60	-	416	

Soudotec 57 FC is a silver nickel torch rod with a very high strength for brazing all these categories

Soudotec 70 is an aluminum electrode DC+ only and can be used for torch brazing

Soudotec 390 is an all position easy applicable hardfacing electrode for all steels