


225 XP AC/DC+

STEEL

DESCRIPTION

Xtra Performance, high strength, **double-coated «extra low hydrogen»** electrode specifically suited for welding medium carbon steel, cast steels, structural steels and heavy equipment parts.

CHARACTERISTICS

- **Exceptional welder appeal**
- Moisture-resistant coating
- Smooth fusion, stable arc and easy slag removal
- High cracking resistance
- Excellent all-position weldability
- Superior mechanical properties, even at low temperatures

TYPICAL APPLICATIONS

Structural steels, cast steels, alloy steels with low content of manganese, chromium and molybdenum, truck frames, farm machinery, excavation equipment and heavy equipment. Ideal for forestry equipment, mining and oil fields and any other application outdoors and in **wet environments**.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** electrode. Maintain a short arc. Remove slag only when the glaze blackens.

MECHANICAL PROPERTIES

Tensile strength:	up to 85 000 psi (586 MPa)
Yield strength:	up to 65 000 psi (450 MPa)
Elongation:	28 - 34%
Impact (Charpy V):	80 J at -20°C

WELDING PARAMETERS

Diameter	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage	170 – 200 A	130 – 190 A	90 – 140 A	60 – 90 A

Electrodes also available: **Selectarc 8225 XP**

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