



220 AC/DC+

ALLOY STEEL

DESCRIPTION

High-strength low-alloy electrode with a basic coating for deposits with **very low diffusible hydrogen content**. Recommended for welding low alloy steels with high yield strength, low to medium carbon steels and steels generally sensitive to cracking.

CHARACTERISTICS

- **High crack-resistant deposit**
- Excellent radiographic quality
- Flame-cuttable deposit
- Excellent weldability in position
- Excellent machinability
- Stable arc and low spatter

TYPICAL APPLICATIONS

Recommended for welding heavy equipment parts, monorails, mining equipment, steels such as T1, Corten, Scandia, CHT, SPS 245, Impacto and Hardox, as well as low alloy steels containing nickel, chromium and molybdenum.

PROCEDURE

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

MECHANICAL PROPERTIES

Tensile strength:	115 000 psi (791 MPa)
Yield strength:	100 000 psi (690 MPa)
Elongation:	21 - 24%
Impact (Charpy V):	65 J at -40°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:	180 - 200 A	140 - 160 A	105 - 125 A	80 - 100 A

Flux-cored wire also available : **Soudotec FC 8220G**

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