


Soudotec 222 SP AC/DC+
STEEL**DESCRIPTION**

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

CHARACTERISTICS

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

TYPICAL 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 212 SP** or **Soudotec G12** electrode. Maintain a short arc. Remove slag between each pass. Weld galvanized steel using straight polarity (DC-) or an AC power supply.

MECHANICAL PROPERTIES

Tensile strength:	80 000 psi (550 MPa)
Yield strength:	64 000 psi (440 MPa)
Elongation:	24 - 28%
Impact (Charpy V):	60 J at 0°C

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	170 - 190 A	120 - 150 A	70 - 90 A

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