


225 AC/DC+

STEEL

DESCRIPTION

Economical double-coated «controlled hydrogen» electrode specifically suited for welding structural steels and heavy equipment parts.

CHARACTERISTICS

- **High cracking resistance**
- Excellent all-position weldability
- Easy striking and restriking, even on AC power supply
- Superior mechanical properties, even at low temperatures
- Moisture-resistant coating
- Smooth fusion, stable arc and easy slag removal

TYPICAL APPLICATIONS

Structural steels, cast steels, alloy steels with low content of manganese, chromium and molybdenum, truck frames, heavy equipment, farm machinery, excavation equipment. Ideal for forestry equipment 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** or **Soudotec G12** electrode. Maintain a short arc. Remove slag only when the glaze blackens.

MECHANICAL PROPERTIES

Tensile strength:	80 000 psi (550 MPa)
Yield strength:	60 000 psi (414 MPa)
Elongation:	32 - 36%
Impact (Charpy V):	70 J at -20°C

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	140 - 190 A	90 - 140 A	60 - 90 A

Flux-cored wire also available: **Soudotec MC 8225G**

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