

**230** AC/DC+**ALLOY STEEL****DESCRIPTION**

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 steels.

CHARACTERISTICS

- **Excellent mechanical properties**
- Very good weldability in position
- Machinable, crack-free deposit
- Corrosion, heat and oxidation resistance
- Impact and wear resistant deposit
- Vast selection of diameters available: 1/16" (1.6 mm) to 3/16" (5.0 mm)

TYPICAL 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 212 SP** or **Soudotec G12** electrode. Maintain a short arc. Peen while still hot between each pass to stress relieve. Remove slag between each pass. For some high alloy steels, preheating is recommended.

MECHANICAL PROPERTIES

Tensile strength:	120 000 psi (827 MPa)
Yield strength:	100 000 psi (690 MPa)
Elongation:	28 - 32%
Impact (Charpy V):	50 J at +20°C
Hardness (as-welded):	21 HRC Work-hardened = 50 HRC

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")	2.0 mm (5/64")	1.6 mm (1/16")
Amperage:	145 - 215 A	100 - 175 A	70 - 125 A	60 - 75 A	40 - 60 A	20 - 45 A

Also available in jet type electrodes version: **Soudotec 275**

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