


**265** AC/DC+

**ALLOY STEEL**

### DESCRIPTION

**Super strength** electrode for welding of high alloy steels and all types of unknown steels together, or as dissimilar assemblies. Excellent as a cushion before hardfacing high alloy steels.

### CHARACTERISTICS

- **Exceptional mechanical properties**
- Excellent weldability, particularly on interior angles
- Machinable, crack-free deposits
- Corrosion, heat and oxidation resistance
- Impact and wear resistance

### TYPICAL APPLICATIONS

Numerous applications involving the maintenance and repair of machine parts, tools, dies, spring steels, as well as the rebuilding of shafts and blades. **Excellent for extracting bolts and studs.**

### 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 some high alloy steels, preheating is recommended.

### MECHANICAL PROPERTIES

Tensile strength:	122 000 psi (841 MPa)			
Yield strength:	100 000 psi (690 MPa)			
Elongation:	30 - 35%			
Impact (Charpy V):	50 J at +20°C			
Hardness (as-welded):	22 HRC		Work-hardened: 52 HRC	

### WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	145 - 195 A	100 - 160 A	70 - 125 A	60 - 85 A

Also available in flux-cored wire: **Soudotec FC 8265G** and TIG rods : **Soudotec T265**

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*Produits et techniques de soudage spécialisé. Pour assistance technique ou pour commander :*