



267 AC/DC+

ALLOY STEEL

DESCRIPTION

Incomparable electrode, with exceptional resistance, designed for applications with extreme stress. Superior for welding of difficult-to-weld steel, especially high alloy steel, tool steel, manganese steel, spring steel, tempered steel and super duplex stainless steel grades.

CHARACTERISTICS

- Exceptional mechanical resistance
- All position weldability
- Fusion very soft and easy
- Very good corrosion, heat and acid resistance
- Exceptional weld bead
- Easy striking and re-striking
- Easy slag removal

TYPICAL APPLICATIONS

Recommended for welding high alloy steel, steel sensitive to cracking, super duplex stainless steel, tool steel, tempered steel, spring steel, turbines, shafts, mining equipment, petroleum industries, wear plates, extreme stress application situations.

PROCEDURE

Clean surface of all traces of oil, grease and dirt. Remove damaged metal or gouge cracks with Soudotec 212 SP or Soudotec G12 electrode. Maintain a short arc. Hot peens between each pass to relieve stress. Remove slag between each pass. For certain high alloy steel, preheating is recommended.

MECHANICAL PROPERTIES

Tensile strength:	140 900 psi (971 MPa)
Yield strength:	104 500 psi (720 MPa)
Elongation:	22 - 27 %
Hardness (as-welded):	240 BH

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	120 - 145 A	80 - 115 A	60 - 80 A

Rév.: 21_08

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