


271 AC/DC +

Cr-Mo STEEL

DESCRIPTION

Low-alloy **chrome-molybdenum** electrode with a basic coating for welding alloy steel and carbon steel. Specifically recommended for welding steel containing 2.25% Cr – 1% Mo and similar grades.

CHARACTERISTICS

- Service temperature up to 550°C (1022°F)
- Excellent welding in all positions
- Stable arc and low spatter
- Good elongation
- Excellent machinability
- Easy to remove slag

TYPICAL APPLICATIONS

Alloy steel with chrome-molybdenum of the 4000 (AISI) grade, construction steel, tubes, motorcycle parts, molds and dies, etc.

PROCEDURE

Clean surface of all oil, grease and dirt. Remove damaged metal or gouge cracks with **Soudotec 212 SP** or **Soudotec G12** electrode. Preheat to 200 - 250°C (392 - 482°F) depending on the composition of the base metal and its thickness. Stress relief maybe required. Cool slowly.

MECHANICAL PROPERTIES

Tensile strength: 90 000 psi (620 MPa)
 Yield strength: 65 300 psi (450 MPa)
 Elongation: 22 - 26 %

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	140- 160 A	105 - 125 A	70 - 90 A

Also available in flux-cored wire: **Soudotec FC 8271G** and TIG rods: **Soudotec T271**

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