



275 AC/DC+

ALLOY STEEL

DESCRIPTION

High-recovery (160%) and **high-strength** electrode for welding high alloy steels, **galvanized steels** and all types of unknown steels together or as dissimilar assemblies. Excellent as a cushion before hardfacing high alloy steels.

CHARACTERISTICS

- **Recommended for welding galvanized steels**
- Exceptional mechanical properties
- Excellent weldability and high deposit rate
- Machinable, crack-free deposits
- Corrosion, heat and oxidation resistance
- Impact and wear resistant

TYPICAL APPLICATIONS

Numerous applications involving the maintenance and repair of machine parts, tools, dies, spring steels, galvanized steels, as well as the rebuilding of shafts and blades.

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: | 120 000 psi (827 MPa) | | |
| Yield strength: | 90 000 psi (620 MPa) | | |
| Elongation: | 26% | | |
| Hardness (as-welded): | 240 BH | Work-hardened: | 500 BH |

WELDING PARAMETERS

| | | | |
|-----------|----------------|---------------|----------------|
| Diameter: | 4.0 mm (5/32") | 3.2 mm (1/8") | 2.5 mm (3/32") |
| Amperage: | 150 – 200 A | 100 – 140 A | 70 – 100 A |

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