

**M8221** DC+**ALLOY STEEL****DESCRIPTION**

**Copper coated medium-alloy solid (GMAW) wire** for assembling medium carbon steels, low alloy steels and high-strength low-alloy (HSLA) steels.

**CHARACTERISTICS**

- Excellent mechanical properties
- Crack-resistant deposit
- Flame-cutable deposit
- Excellent weldability in position

**TYPICAL APPLICATIONS**

**Specially designed for joining and repairing band saws in sawmills or other related sectors.** Also adapted for various steels such as Jalloxy, 4130, 4140, 4340, T1, HY-90, SPS 245, CHT 360, SS-100, 400, 500, Scandia 100-200-300-400 Brinell, etc., as well as pipes, plates and parts for heavy equipment, construction equipment and mining equipment, such as blades, buckets, telescopic arms, cranes, booms, shovels, etc.

**PROCEDURE**

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec 212 SP** or **Soudotec G12**. On thick sections, preheating is recommended. Let cool slowly. Grind the weld as required. Post-heating at 670°C (1240 °F) is recommended when welding band saws.

**MECHANICAL PROPERTIES**

Tensile strength:	100 000 psi (690 MPa)
Yield strength:	75 000 psi (517 MPa)
Elongation:	23 %
Impact (Charpy V):	80 J at +20°C

**WELDING PARAMETERS**

Gas:	100 % CO <sub>2</sub> or Argon / CO <sub>2</sub> Mixture
Diameter:	.045" (1.2 mm)      .030" (0.8 mm)
Amperage:	140 - 210 A      100 - 160 A
Voltage:	23 - 29 V      16 - 20 V
Stick-out:	3/8" - 3/4"      3/8" - 3/4"
Gas flow rate (c.f.h):	20 - 25      20 - 25

Packaging: 5 or 15 kg spool

Rev.: 21\_08

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