


MC 8225G DC+
STEEL
DESCRIPTION

Low alloy "controlled hydrogen" type **gas shielded** metal-cored wire (MCAW) **without slag**. From a unique concept : **the shell is WELDED, DRAWN OUT AND COPPER COATED** specifically suited for repair welding of structural steels and heavy equipment parts.

CHARACTERISTICS

- **Excellent weldability**
- Low hydrogen content
- Exceptional moisture resistance
- High cracking resistance
- Superior mechanical properties, even at low temperatures
- Better current carrying capability
- Improved arc stability and regular feed

TYPICAL APPLICATIONS

Structural steels, cast steels, alloy steels with low content of manganese, chromium and molybdenum, truck frames, heavy equipment, farm machinery, excavation equipment. Ideal for forestry equipment and any other application outdoors and in wet environments. Let cool slowly.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** or **Soudotec G12** electrode. For high thickness parts, preheating is recommended. Let cool slowly.

MECHANICAL PROPERTIES

Tensile strength:	> 80 000 psi (> 550 MPa)
Yield strength:	> 68 000 psi (> 470 MPa)
Elongation:	32 - 36%
Impact (Charpy V):	> 60 J at -40°C

WELDING PARAMETERS

Gas:	Ar/CO ₂ mixture	
Diameter :	.045" (1.2 mm)	1/16" (1.6 mm)
Amperage:	130 - 290 A	190 - 380 A
Voltage:	22 - 28 V	25 - 33 V
Stick-out:	1/2" - 5/8"	1/2" - 3/4"
Gas flow rate (c.f.h):	40 - 50	40 - 50

Packaging: 5 kg and 15 kg spool

Electrodes also available: **Soudotec 225**

Rév.: 21_08

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