

## Selection guide for Soudotec welding electrodes

Electrodes and metal base	Mild steel	Cast steel	Alloy steel	Low alloy steel T1	Unknown stainless steel	Manganese steel	Structural steel	Tool steel	Cast iron	Oily cast iron	Machinable cast iron	Burnt cast iron	Copper alloy
<b>Mild steel</b>	222/222SP 214 21	Special 277 206	265 230 277	220 277 206	277 265 230	277 342 206	Spécial 277 206	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 563 561
<b>Cast steel</b>	Special 206	Special 206	265 277	220 206	277 230	277 342 206	Special 277 206	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 563 561
<b>Alloy steel</b>	265 230 277	265 230 277	265 230 277	265 230 277	265 230 277	265 206 277	265 230 277	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 563 561
<b>Low alloy steel T1</b>	220 277 206	220 277 206	265 230 277	220 277 206	277 265 230	277 342 206	220 277 206	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 563 561
<b>Unknown stainless steel</b>	265 206	265 206	277 277	265 206	265 206	265 206	265 206	265 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 563 561
<b>Manganese steel</b>	342 277 206	277 342 206	265 206 277	277 265 206	277 265 206	342 277 206	342 277 206	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 563 561
<b>Structural steel</b>	Special 206	Special 206	265 277	277 265 206	277 265 206	342 277 206	Special 277 206	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 563 561
<b>Tool steel</b>	265 230 277	265 230 277	265 230 277	265 230 277	265 230 277	265 230 277	265 230 277	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 BF 189 SP/BF	168 189 SP/BF	536 561 563
<b>Cast iron</b>	160 189 SP/BF	189 SP/BF 160	160 189 SP/BF	189 SP/BF 160	189 SP/BF 160	160 189 SP/BF	189 SP/BF 160	189 SP/BF 160	160 189 SP/BF	160 189 SP/BF	169 BF 189 SP/BF	168 189 SP/BF	536 561/563
<b>Oily Cast iron</b>	160 189 SP/BF	189 SP/BF 160	189 SP/BF 160	189 SP/BF 160	189 SP/BF 160	189 SP/BF 160	160 189 SP/BF	189 SP/BF 160	160 189 SP/BF	160 189 SP/BF	169 BF 189 SP/BF	168 189 SP/BF	536 561/563
<b>Machinable cast iron</b>	169 BF 179	169 BF 179	169 BF 179	169 BF 179	169 BF 179	169 BF 179	169 BF 179	169 BF 179	169 BF 169 BF	169 BF 169 BF	169 BF 179	168 169 BF	536 561/563
<b>Burnt cast iron</b>	168 189 SP/BF	168 189 SP/BF	168 189 SP/BF	168 189 SP/BF	168 189 SP/BF	168 189 SP/BF	168 189 SP/BF	168 189 SP/BF	168 165	168 189 SP/BF	168 169 BF	168 189 SP/BF	536 561/563
<b>Copper alloy</b>	536 561/563	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536	561/563 536

\*Soudotec 1690 and 1690 SP are also high-performance electrodes for applications on all types of steel presented in this table (Inconel)

\*Each application category presented in this table indicates the recommended products by order of preference

\*This table is not restrictive; other Soudotec products are suited for these applications, please consult **FSH Welding Canada's** Technical Department

\*Copper alloy 561: AC current only