

ARCTEC® WS 2200



GENERAL CHARACTERISTICS:

ARCTEC® WS 2200 is an all position solid bare welding wire for automatic and semiautomatic welding of cast iron. For use with a 75% Argon and 25% CO₂ shielding gas.

APPLICATIONS:

ARCTEC® WS 2200 is suitable for welding of ductile, malleable and grey cast iron. May be used for joining cast iron to mild steel and join or repair welding of defective, worn or broken castings.

WELDING PROCEDURES:

Clean area to be welded free of oil, grease, rust and other contaminants. Pre and postheat treatment is not usually required but may be advantageous when welding heavy section of low ductility castings.

MECHANICAL PROPERTIES:

Tensile Strength 90,000psi 620MPa	Yield Strength 55,000psi 380MPa	Elongation 25% in 2"	Typical Hardness 195-225 HB
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OPERATING PARAMETERS:

WELDING PROCESS: GMAW

POLARITY: DC Reverse

SHIELDING GAS AND FLOW RATE:
Short-arc 75% Argon/25% CO₂ at 35-45 CFH

Wire Diameter	Shielding Gas	Operating Parameters		Amps	Volts
		Wire Feed in/min	Travel Speed in/min		
.045" 1.2mm	75% Argon 25%CO ₂	250-500	10-25	180-280	26-32
1/16" 1.6mm	75% Argon 25%CO ₂	150-225	10-25	235-320	26-30

STANDARD SIZE AND PACKAGING:

Size	Packaging	
1.2mm	11.3Kg	13.6Kg

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