ARCTEC® 221 RP

GENERAL CHARACTERISTICS:

ARCTEC® 221 RP is an all position electrode designed for use with AC or DC reverse polarity. This electrode produces an easily controlled forceful arc with deep penetration and has good re-striking characteristics. Has excellent welding characteristics in all positions and produces sound crack free deposits.

APPLICATIONS:

ARCTEC® 221 RP is designed primarily for joining of mild steels. Typical applications include fabrication and repair of mild steel structures, tanks and piping. Ideal for applications where an aggressive arc is required.

WELDING PROCEDURE:

Clean weld area free from oil, grease, rust and other contaminants. Maintain short arc with electrode tilted at 5 to15º in direction of travel. For weave beads use a slight oscillating motion. Allow slag to cool before removing between passes. Preheating and postweld heat treatment is generally not required but may be specified or recommended for the base material.

MECHANICAL PROPERTIES:

Tensile Strength	Elongation
Up to 76.100 psi	22-24% - 2"
(525 MPa)	

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: AC or DC Reverse

RECOMMENDED AMPERAGE:

Diameter	2.50mm (3/32")	3.25mm (1/8")	4.00mm (5/32")
Amperage	60-80	90-130	130-160

Subject to change without notice