

# ARCTEC® 222



## GENERAL CHARACTERISTICS:

ARCTEC® 222 is a specially developed all position low alloy steel electrode for fabrication and maintenance work. It produces smooth, spatter free welds with either AC or DC equipment. Can be used as a contact electrode. Easy slag removal guarantees a minimum of clean up and finishing. Has excellent welding characteristics in all positions and produces sound crack free deposits.

## APPLICATIONS:

ARCTEC® 222 is recommended for general maintenance and repair welding as it produces welds that are virtually spatter free. Excellent for welding thin gauge sheet metal without slag interference. ARCTEC® 222 is used on: Ornamental iron components, railings, furniture, galvanized sheet metal, thin gauge steel, vehicle exhaust systems and other applications where a clean surface for painting is required.

## WELDING PROCEDURE:

Clean weld area and observe good welding practices. Maintain short arc with electrode tilted about 15° in direction of travel. In cases of poor fit up, weave beads are suggested to permit faster welding without burn through. Remove slag between passes.

## MECHANICAL PROPERTIES:

Tensile Strength	Yield Strength	Elongation
75000-80000psi (517-551 MPa)	71,500 (495 Mpa)	27% - 2"

## OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Straight or AC

### Recommended Amperage:

Diameter	1.50mm 1/16"	2.00mm 5/64"	2.50mm 3/32"	3.25mm 1/8"	4.00mm 5/32"	5.00mm 3/16"
Amperage	30-40	40-60	60-100	100-140	120-160	170-220

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