

ARCTEC® 224 (SUPER 18)

Conforms to: AWS 5.1 Class E-7018



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 224 (SUPER 18) is a basic iron powder coated electrode with controlled hydrogen content that greatly reduces the possibility of underbead cracking. The weld deposit has a good ability to withstand deformation in rigid structures where high welding stresses are unavoidable. Has excellent welding characteristics in all positions and produces solid crack free deposits.

APPLICATIONS:

ARCTEC® 224 (SUPER 18) is suitable for build up and repair of a wide range of fine grained medium carbon and low alloy steels requiring higher impact strength welds. For items such as mild steel structures and repair of construction and mining equipment. For welding of steels sensitive to cracking and cast steel pump housings.

WELDING PROCEDURE:

By observing good welding practices and electrode care associated with low hydrogen content electrodes and taking into consideration heat input and the control of hydrogen, by maintaining a short arc length, in the welding process excellent results can be consistently attained. To meet impact strength requirements preheat and postheat may be recommended on heavier sections to reduce hardness and control stress in the weld area which will further enhance the weld deposits resistance to underbead cracking.

MECHANICAL PROPERTIES:

Tensile Strength	Yield Strength	Elongation	ft/lb.	Impact Strength	
				Joules	Temperature
76,800-80,000 psi 530-550 MPa	65,000-71,000 psi 450-490 MPa	30-32% - 2"	80	110	Ambient

OPERATING PARAMETERS:

WELDING PROCESS: SMAW
POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	2.50mm 3/32"	3.25mm 1/8"	4.0mm 5/32"	5.0mm 3/16"	6.0mm 1/4"
Amperage	60-90	80-110	110-140	150-180	180-210

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