



a quality welding alloy

ARCtec® 226X

Classifications: AWS A 5.5 Class E8018-C1
DIN 8529: EY 46 87 2 Ni B

GENERAL CHARACTERISTICS:

ARCtec® 226X is a basic coated low hydrogen electrode yielding a weld deposit with a nominal 2.5% Nickel content which allows the weld deposit to meet the required mechanical properties of high strength low alloy steels in low temperature conditions with excellent welding characteristics in all positions. The weld deposit is machinable.

APPLICATIONS:

ARCtec® 226X is recommended for welding of high strength low alloy and nickel bearing steels and is suitable for service conditions where low temperature toughness of the weld deposit is required. ARCtec® 226X is outstanding in the fabrication and maintenance welding of heavy construction equipment where maximum loading at low temperature is a possibility, Applications include: Drag line undercarriages, booms, bucket shells and track equipment, heavy truck frames and boxes, cylinder mounts and rams.

WELDING PROCEDURE:

By observing good welding practices and taking into consideration heat input and control of hydrogen in the welding process excellent results can be consistently attained. To meet impact strength requirements preheat and postheat is recommended to reduce hardness and control stress in the weld area.

MECHANICAL PROPERTIES:

Tensile Strength	Yield Strength	Elongation
80,000-90,000 psi	66,700-72,500 psi	28% - 2"
550-620 MPa	379-482 MPa	
	Impact Strength	
ft/lbs	Joules	Temperature
125	170	0°C / 32°F
110	150	-20°C / -4 °F
55	75	-60°C / -76°F

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"
Amperage	80-100	120-140	160-180	220-240

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