

ARCTEC® 264 HIGH ALLOY STEEL



GENERAL CHARACTERISTICS:

ARCTEC® 264 is a versatile, easy to use, low heat maintenance welding alloy for joining and build up applications on most ferrous steels. This electrode has excellent weldability in all positions and produces finely rippled, crack resistant, spatter free deposits that are fully machineable. The deposit has good heat and corrosion resistance.

APPLICATIONS:

ARCTEC® 264 is suitable for joining and build up of dissimilar steels, tool and die repair, spring steel and as a cushion layer for hard overlays. Suitable for service temperatures up to 350°C.

WELDING PROCEDURE:

Clean weld area free from oil, grease, rust and other surface contaminants. Bevel heavy section before welding. Maintain a short arc and use stringer beads to prevent overheating. Allow deposit to cool before removing slag. Preheating and postweld heat treatment is generally not required, but may be specified or recommended for the base material.

MECHANICAL PROPERTIES:

Tensile Strength	Yield Strength	Elongation
115,000 psi	80,000 psi	Approx.
790 MPa	550 MPa	25% - 2"

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"
Amperage	60-80	80-100	110-130

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