

ARCTEC® 275 W



GENERAL CHARACTERISTICS:

ARCTEC® 275 W is designed for joining of carbon, low alloy, chrome nickel and austenitic stainless steels to each other or to other grades of steel. The flow characteristics and deposition rate of this electrode also make it suitable for build up and cladding applications. ARCTEC® 275W produces a smooth, dense and highly crack resistant deposit that is easily machined. Weld deposit is acid and corrosion resistant.

APPLICATIONS:

ARCTEC® 275 W is excellent for welding steel sensitive to cracking. This electrode is suitable for joining manganese and carbon steel to each other or to other grades of steel. Recommended for repair and build up of shafts and pins and as a cushion layer in preparation for hard facing.

WELDING PROCEDURE:

Remove all scale, grease and dirt from the weld zone and prepare joints as required. Observe good welding practices, including application of pre and post heat where necessary.

MECHANICAL PROPERTIES:

Tensile Strength	Yield Strength	Elongation	ft/lbs	Impact Strength		Hardness
				Joules	Temperature	
86,000 psi 592 Mpa	56,800 psi 391 Mpa	30% - 2"	44-65	60-90	Ambient	200 - 300 HB

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	60-90	80-110	110-140

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