



a quality welding alloy

# ARCTEC® 293XC

**Classifications:** Conforms to AWS A 5.5 Class E10018-M

## GENERAL CHARACTERISTICS:

ARCTEC® 293XC is an all position, high tensile, low hydrogen type electrode designed to produce welds with high tensile strength on most ferrous steels. This electrode has good weldability in all positions and provides smooth, porosity free welds without undercut and spatter.

## APPLICATIONS:

ARCTEC® 293XC is recommended for joining and repair of carbon steels, low alloy steels and cast steel. Ideal for high stress area repairs, such as frames, grapples, forks and equipment components.

## WELDING PROCEDURE:

Clean weld area free from oil, grease, rust and other surface contaminants. Bevel heavy sections before welding. Maintain a short arc and use stringer beads to prevent overheating and electrode care associated with low hydrogen electrodes. 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/lbs	Impact Strength	
				Joules	Temperature
Up to 105,900 psi	Up to 94,300 psi	24% - 2"	117	158	20°C (68°F)
(730 Mpa)	(650 Mpa)		50	68	-51°C (-60°F)
			35	48	-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")
Amperage	80-110	90-140	140-190

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CALGARY FAX:(403)-250-7682    EDMONTON: (780)-484-4896    VANCOUVER: (604)-596-2940    WINNIPEG: (204)-663-7955  
PHONE:(403)-250-9355    (780)-484-3304    (604)-596-6207    (204)-663-9182

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