

# ARCTEC® 220



a quality welding alloy

## GENERAL CHARACTERISTICS:

ARCTEC® 220 is a medium coated low alloy all position electrode for general maintenance and repair work. This electrode has good downhand welding qualities, good penetration and excellent ignition and re-ignition.

## APPLICATIONS:

ARCTEC® 220 is recommended for general maintenance, repair and production welding. Suitable for welding thin gauge sheet metal without slag interference. ARCTEC® 220 is used for ornamental iron components, railings, steel furniture, vehicle and farm machinery components.

## WELDING PROCEDURE:

Clean weld area thoroughly and prepare weld joint as required. Maintain short arc with electrode inclined slightly in the direction of travel. In cases of poor fit up, weave beads are suggested to prevent burn through. Use DC Reverse polarity for improved penetration.

## MECHANICAL PROPERTIES:

Tensile Strength 70,000-76,000 psi (482-524 Mpa)	Yield Strength 65,000-68,000 psi (448-468 MPa)	Elongation 20-25% - 2"
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## OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Straight or Reverse or AC

### Recommended Amperage:

Diameter	2.50mm 3/32"	3.25mm 1/8"	4.00mm 5/32"	5.00mm 3/16"
Amperage	50-70	70-90	100-120	130-150

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