

ARCTEC® 223XC®



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 223XC® is a high strength and highly crack resistant electrode for welding of medium carbon and cast steel. Has very good ability to withstand deformation in rigid structures where high welding stresses exists. Has excellent welding characteristics in all positions and produces sound crack free deposits. Metal recovery is approximately 115%.

APPLICATIONS:

ARCTEC® 223XC® is recommended for repair welding of a wide range of mining and construction equipment, for joining of steel frames, crusher parts and cast steel components. Outstanding for welding steels sensitive to cracking. Also suitable for build up and repair of steel castings.

WELDING PROCEDURE:

Clean surface contaminants from weld area. By observing good welding practices and electrode care associated with low hydrogen electrodes and taking into consideration heat input and the control of hydrogen, by maintaining a short arc length in the welding process, excellent results can be consistently attained. 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
80,000-85,000 psi	65,000-77,000 psi	28-34% - 2"	150-173	203-234	Ambient
555-590 MPa	450-535 MPa		55-62	75-84	-40°C

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"	6.0mm 1/4"
Amperage	80-100	120-140	150-180	200-250	280-340

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