ARCTEC® UNICROM® 265-S

a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® UNICROM® 265-S is a ferritic austenitic electrode with outstanding welding properties. The high content of alloying constituents ensures sound heat, corrosion and crack resistant weld deposits. Weld and transition zones are fully machinable. The special coating provides easy manipulation in all positions (except vertical down) and low heat input ensures dense and spatter free deposits.

APPLICATIONS:

ARCTEC UNICROM® 265-S is a superior low heat electrode for joining and build up of dissimilar steels. Recommended for high strength, impact and corrosion resistant welds on heavy construction and mining equipment. The repair of spring steels, gears, shafts, splines, tool and die steel and cushion layers for hard overlays, are only some of the applications for this versatile alloy. Suitable for service temperatures up to 350°C.

WELDING PROCEDURE:

Clean surface contaminants from weld area, bevel heavy sections before welding. Preheating and postweld heat treatment is unnecessary for the weld metal, but may be specified or recommended for the base material.

MECHANICAL PROPERTIES:

		Impact Strength		
Tensile Strength	Yield Strength	ft/lbs	Joules	Temperature
120,000 psi 830 MPa	85,000 psi 588 MPa	37	50	Ambient

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	1.5 mm 1/16"	2.0 mm 5/64"	2.50 mm 3/32"	3.25 mm 1/8"	4.0 mm 5/32"	5.0 mm 3/16"
Amperage	30-50	40-60	60-80	80-100	110-140	140-180

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