



a quality welding alloy

ARCtec® 278 ALLOY STEEL

GENERAL CHARACTERISTICS:

ARCtec® 278 is a fabrication and maintenance electrode suitable for the joining of carbon and alloyed steels as well as austenitic manganese steel to each other or to other grades of steel. Weld deposit is resistant to frictional wear and has good strain hardening properties. ARCtec® 278 has outstanding welding characteristics in all positions and is highly crack resistant.

APPLICATIONS:

ARCtec® 278 is excellent for the joining of dissimilar steel, the cladding of carbon steel and the repair and installation of manganese bucket lips, teeth to bucket shells and shaft build up. The installation and hard surfacing preparation of pipeline ditcher segments is a common use of ARCtec® 278. The recommended electrode for installation of ARCtec® wearplates is ARCtec® 278.

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 postheat where necessary.

MECHANICAL PROPERTIES:

Tensile Strength	Yield Strength	Elongation	ft/lbs	Impact Strength	Joules	Temperature
85,000 psi	50,000 psi	35% - 2"	44-65	60-90		Ambient
585 Mpa	350 Mpa					

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"	5.0 mm 3/16"
Amperage	60-90	80-110	110-140	150-180

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