

**206 AC/DC+****ALLOY STEEL****DESCRIPTION**

**High-recovery (160%)** electrode containing manganese for welding and building up low alloy and high alloy steels, manganese steels (11-14% Mn) and difficult-to-weld steels.

**CHARACTERISTICS**

- **Exceptional weldability and high deposit rate**
- Work hardening deposit
- Crack free deposit
- Ideal as a cushion before hardfacing
- Excellent corrosion, oxidation and impact resistance
- Dense and porosity free deposit
- Stable arc and very low spatter
- High temperature resistance

**TYPICAL APPLICATIONS**

Dissimilar assemblies. Recommended for high-strength steels, manganese steels, T1, CHT 360, Scandia, SPS 245 steels; propellers, pumps, valves, crusher rolls, railroad switches, rails, construction equipment, etc. **Excellent as a cushion before hardfacing.**

**PROCEDURE**

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec 212 SP** or **Soudotec G12** electrode. Maintain a short arc. Remove slag between each pass. For some high alloy steels, preheating is recommended.

**MECHANICAL PROPERTIES**

Tensile strength:	95 000 psi (655 MPa)	
Yield strength:	75 000 psi (517 MPa)	
Elongation:	38%	
Hardness (as-welded):	250 BH	Work-hardened: 525 BH

**WELDING PARAMETERS**

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	180 – 230 A	150 – 210 A	110 – 150 A

Flux-cored wire also available: **Soudotec FC 8206G**

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*Specialized welding alloys and technology. For technical assistance or for ordering:*