

**214** AC/DC+**STEEL****DESCRIPTION**

Cost-efficient universal-use electrode for welding mild steels.

CHARACTERISTICS

- **Easy striking and restriking (OCV = 40 V)**
- Extremely smooth fusion
- Excellent on AC power supply, very low amperage
- Wide variety of applications in all positions
- Moisture-resistant coating
- Easy slag removal

TYPICAL APPLICATIONS

Recommended for welding structural steelwork, body work, farm equipment, metal work, as well as handicrafts work and thin or galvanized sheets.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** or **Soudotec G12** electrode. Maintain a short arc. Remove slag between each pass.

MECHANICAL PROPERTIES

Tensile strength:	75 000 psi (516 MPa)
Yield strength:	60 000 psi (413 MPa)
Elongation:	23 - 26%
Impact (Charpy V):	50 J at 0°C

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	130 - 160 A	100 - 120 A	60 - 80 A

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