

**222 AC/DC+****STEEL****DESCRIPTION**

Electrode specially designed for welding mild steels and specifically **galvanized steels**.

CHARACTERISTICS

- **All-position welding, including vertical down**
- Excellent on AC power supply, low amperage
- Ideal for thin sheets
- Flexible moisture-resistant coating
- Easy striking and restriking (OCV = 40 V); ideal for tack welds
- Easy slag removal
- Vast selection of diameters available: 1/16" (1.6 mm) to 3/16" (5.0 mm)

TYPICAL APPLICATIONS

Recommended for steel furniture, thin sheet metal, farm machinery, body work and specifically for galvanized steel.

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. Weld galvanized steel using straight polarity (DC-) or an AC power supply.

MECHANICAL PROPERTIES

Tensile strength:	80 000 psi (550 MPa)
Yield strength:	64 000 psi (440 MPa)
Elongation:	24 - 28%
Impact (Charpy V):	60 J at 0°C

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")	2.0 mm (5/64")	1.6 mm (1/16")
Amperage:	190 - 230 A	170 - 190 A	120 - 150 A	70 - 90 A	40 - 60 A	30 - 45 A

Also available in solid MIG wire: **Soudotec M500**

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