

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

High strength electrode for welding alloy and carbon steels, **unknown stainless steels**, tempered steels, manganese steels and difficult-to-weld steels requiring maximum elongation.

CHARACTERISTICS

- **Crack-resistant deposit**
- Excellent heat (950°C/1742°F), corrosion and vibration resistance
- Machinable deposit
- Contact electrode
- Excellent on AC power supply
- Spatter free and easy slag removal

TYPICAL APPLICATIONS

Recommended for steels susceptible to cracking, difficult-to-weld steels, unknown stainless steels, tempered steels, manganese steels, truck frames, railroad switches, chain links, gear teeth, etc. Excellent as a cushion before hardfacing on tool steel.

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:	100 000 psi (689 MPa)
Yield strength:	68 000 psi (468 MPa)
Elongation:	38 - 45%
Impact (Charpy V):	60 J at +20°C

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	140 – 180 A	90 – 140 A	75 – 110 A	45 – 75 A

Also available in flux-cored wire : **Soudotec FC 8277G** and TIG rods : **Soudotec T277**

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