

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

Economical high-strength electrode for welding high carbon and high alloy steels. Highly recommended for welding all types of unknown steels between themselves or as dissimilar assemblies.

CHARACTERISTICS

- **Excellent mechanical properties**
- Good weldability in position
- Machinable, crack-free deposit
- Corrosion, heat and oxidation resistance
- Impact and wear resistant deposit

TYPICAL APPLICATIONS

Repair of spring blades, drill bits, molds, dies, chains, mechanical shovel parts, crane booms, axles, shafts, tool steels, cast steels, armour steels, etc.

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. Peens while still hot between each pass to stress relieve. Remove slag between each pass. For some high alloy steels, preheating is recommended.

MECHANICAL PROPERTIES

| | |
|-----------------------|---|
| Tensile strength: | 118 000 psi (813 MPa) |
| Yield strength: | 100 000 psi (690 MPa) |
| Elongation: | 27 - 30% |
| Impact (Charpy V): | 45 J at +20°C |
| Hardness (as-welded): | 20 HRC Work-hardened: 48 HRC |

WELDING PARAMETERS

| | | | |
|-----------|----------------|---------------|----------------|
| Diameter: | 4.0 mm (5/32") | 3.2 mm (1/8") | 2.5 mm (3/32") |
| Amperage: | 100 - 175 A | 70 - 125 A | 60 - 75 A |

Rév.: 21_08

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