


**SPECIAL AC/DC+**
**STEEL**
**DESCRIPTION**

Unique **double-coated «controlled hydrogen»** electrode with low alloy core specifically suited for welding structural steels and heavy equipment parts.

**CHARACTERISTICS**

- **Excellent moisture resistance, resulting in crack-free deposits**
- Exceptional all-position weldability
- Easy striking and restriking, even on AC power supply
- Superior mechanical properties, even at low temperatures
- Very stable arc and low spatter
- Easy slag removal and very low risk of inclusion

**TYPICAL APPLICATIONS**

Structural steels, cast steels, alloy steels with low content of manganese, chromium and molybdenum, truck frames, heavy equipment, farm machinery, excavation equipment. Ideal for forestry equipment and any other application outdoors and in wet environments.

**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 only when the glaze blackens.

**MECHANICAL PROPERTIES**

Tensile strength: 85 000 psi (586 MPa)  
 Yield strength: 65 300 psi (450 MPa)  
 Elongation: 26 - 40%  
 Impact (Charpy V): 100 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:	190 - 250 A	140 - 190 A	90 - 140 A	60 - 90 A

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