

**Soudotec 21**

AC/DC+

**STEEL****DESCRIPTION**

Cellulosic coated electrode specifically recommended for all-position welding on **rusty, painted, dirty or oily mild steel**.

**CHARACTERISTICS**

- High penetration electrode
- Welding of badly prepared joints
- Moisture and porosity resistance
- Fast freeze deposit
- Easy striking and re-striking
- Easy slag removal
- Pass on pass without slag removal (difficult areas)

**TYPICAL APPLICATIONS**

Recommended for manure spreaders and salt distributors, farm equipment, trailers, etc. Excellent for root passes.

**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. The removal of slag between each pass is recommended. May be used on low-voltage AC power supply.

**MECHANICAL PROPERTIES**

Tensile strength:	80 000 psi (550 MPa)
Yield strength:	65 000 psi (447 MPa)
Elongation:	26%
Impact (Charpy V):	45 J at -10°C

**WELDING PARAMETERS**

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	130 - 170 A	90 - 130 A	50 - 80 A

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