

Soudotec **M8221**

DC+

ALLOY STEEL**DESCRIPTION**

Copper coated medium-alloy solid (GMAW) wire for assembling medium carbon steels, low alloy steels and high-strength low-alloy (HSLA) steels.

CHARACTERISTICS

- Excellent mechanical properties
- Crack-resistant deposit
- Flame-cuttable deposit
- Excellent weldability in position

TYPICAL APPLICATIONS

Specially designed for joining and repairing band saws in sawmills or other related sectors. Also adapted for various steels such as Jalloxy, 4130, 4140, 4340, T1, HY-90, SPS 245, CHT 360, SS-100, 400, 500, Scandia 100-200-300-400 Brinell, etc., as well as pipes, plates and parts for heavy equipment, construction equipment and mining equipment, such as blades, buckets, telescopic arms, cranes, booms, shovels, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec 212 SP** or **Soudotec G12**. On thick sections, preheating is recommended. Let cool slowly. Grind the weld as required. Post-heating at 670°C (1240 °F) is recommended when welding band saws.

MECHANICAL PROPERTIES

Tensile strength: 100 000 psi (690 MPa)
 Yield strength: 75 000 psi (517 MPa)
 Elongation: 23 %
 Impact (Charpy V): 80 J at +20°C

WELDING PARAMETERS

Gas:	100 % CO ₂ or Argon / CO ₂ Mixture	
Diameter:	.045" (1.2 mm)	.030" (0.8 mm)
Amperage:	140 - 210 A	100 - 160 A
Voltage:	23 - 29 V	16 - 20 V
Stick-out:	3/8" - 3/4"	3/8" - 3/4"
Gas flow rate (c.f.h):	20 - 25	20 - 25

Packaging: 5 or 15 kg spool

Rev.: 7_01

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