

Selection guide for Soudotec welding electrodes

Electrodes and metal base	Mild steel	Cast steel	Alloy steel	Low alloy steel T1	Unknown stainless steel	Manganese steel	Structural steel	Tool steel	Cast iron	Oily cast iron	Machinable cast iron	Burnt cast iron	Copper alloy
Mild steel	22/22/22SP 214	Special 277	265 230 277	220 277 206	277 265 230	277 342 206	Special 277	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 SP/BF 189 SP/BF	168 189 SP/BF	536 563 561
	Special 21	Special 277	265 230 277	220 277 206	277 265 230	277 342 206	Special 277	265 230 277	160 189 SP/BF 165	160 189 SP/BF 165	169 SP/BF 189 SP/BF	189 SP/BF 168	536 563 561
Alloy steel	265	265	265	265	265	265	265	265	160	160	169 SP/BF	189 SP/BF	536
	230	230	230	230	230	230	230	230	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	563
Low alloy steel T1	277	277	277	277	277	277	277	277	165	165	169 SP/BF	189 SP/BF	561
	206	206	277	206	230	206	206	277	165	165	169 SP/BF	189 SP/BF	561
Unknown stainless steel	265	265	265	265	265	265	265	265	189 SP/BF	189 SP/BF	169 SP/BF	189 SP/BF	536
	230	230	230	230	230	230	230	230	169 SP/BF	169 SP/BF	189 SP/BF	189 SP/BF	563
Manganese steel	342	277	265	277	277	342	342	265	189 SP/BF	189 SP/BF	169 SP/BF	189 SP/BF	563
	277	342	206	206	206	277	277	230	169 SP/BF	169 SP/BF	189 SP/BF	189 SP/BF	561
Structural steel	Special	Special	265	277	277	342	Special	265	160	160	169 SP/BF	189 SP/BF	536
	206	206	277	206	206	206	277	277	165	165	169 SP/BF	189 SP/BF	561
Tool steel	265	265	265	265	265	265	265	265	160	160	169 SP/BF	189 SP/BF	536
	230	230	230	230	230	230	230	230	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	561
Cast iron	160	189 SP/BF	160	189 SP/BF	189 SP/BF	160	189 SP/BF	189 SP/BF	160	160	169 SP/BF	189 SP/BF	536
	189 SP/BF	160	189 SP/BF	160	160	189 SP/BF	160	160	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	561/563
Oily cast iron	160	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	160	189 SP/BF	189 SP/BF	160	160	169 SP/BF	189 SP/BF	536
	189 SP/BF	160	160	160	160	160	189 SP/BF	160	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	561/563
Machinable cast iron	169 SP/BF	169 SP/BF	169 SP/BF	169 SP/BF	169 SP/BF	169 SP/BF	169 SP/BF	169 SP/BF	189 SP/BF	189 SP/BF	169 SP/BF	169 SP/BF	536
	179	179	179	179	179	179	179	179	169 SP/BF	169 SP/BF	169 SP/BF	169 SP/BF	561/563
Burnt cast iron	168	168	168	168	168	168	168	168	168	168	168	168	536
	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	189 SP/BF	165	189 SP/BF	169 SP/BF	189 SP/BF	561/563
Copper alloy	536	561/563	536	536	536	536	536	536	536	536	561/563	561/563	536
	561/563	536	561/563	561/563	561/563	561/563	561/563	561/563	561/563	561/563	561/563	561/563	561/563

*Soudotec 1690 SP are also high-performance electrodes for applications on all types of steel presented in this table (Inconel)

*Each application category presented in this table indicates the recommended products by order of preference

*This table is not restrictive; other Soudotec products are suited for these applications, please consult FSH Welding Canada's Technical Department

*Copper alloy 561: AC current only