

Model SW 221

Description: high alloy electrode for welding carbon steels, austenitic, ferrous and manganese stainless steels. Steels for springs, stainless steel construction steels and buffer layers on replacements.

Applications: parts exposed to stress and wear by friction, public works, railways, mines, cement works, quarries, agricultural machinery, teeth and blades for scoops, ladles and buckets.

Features:

- Breakage load: $> 600\text{N/mm}^2$ ($> 60\text{kg/mm}^2$).
- Elastic limit: $> 400\text{N/mm}^2$ ($> 40\text{kg/mm}^2$).
- Stretching: $L=5d > 30\%$.
- Charpy Resilience: > 70 Jules (Charpy v).

Welding current: alternating/direct electrode(+).

Welding intensity: diameter 2.5 $> 70\text{A}$ / 3.25 $> 100\text{A}$ / 4.0 $> 125\text{A}$ / 5.0 $> 160\text{A}$.

Welding positions: all positions.