



High Strength and Ductility
under Tough Conditions

Xuper[®] 2222 XHD



- For use with flame-hardening equipment
- Formulated for high speed welding of critically stressed applications
- Excellent for high temperature and sub-zero cryogenic applications

Xuper® 2222 XHD

Xuper 2222 XHD is a nickel-based electrode formulated for high-speed, high-deposition welding of critically stressed applications. Deposits exhibit superior crack resistance and ductility. This easily handled electrode is ideal for welding large cross sections in a variety of steels where cool-down stresses can be a problem. Xuper 2222 XHD maintains a high-tensile strength at high temperatures 1200°F (648°C) as well as in cryogenic applications.

TECHNICAL DATA

Typical Values	
Tensile Strength:	90,000 psi (620 N/mm ²)
Yield Strength:	65,000 psi (450 N/mm ²)
Elongation (1=5d) min.:	42%
Hardness:	180 BHN

SUGGESTED WELDING PARAMETERS:

Diameter	Amperage
3/32" (2.4mm)	80 - 120
1/8" (3.2mm)	110 - 160
5/32" (4.0mm)	150 - 190

Note: When welding with Xuper 2222 XHD make sure to remove ALL sources of sulfur, often an ingredient in both oils and greases.

PROCEDURE FOR USE

PREPARATION: Remove all contaminants, particularly oil and grease. Lightly grind surface to remove superficial oxides. Preheating is not necessary unless the part has a large cross-section or has high air hardenability. In these situations preheating within a range of 250°-300°F (121°-149°C) is advised.

TECHNIQUE: Always use the lowest practical amperage range to minimize dilution. Use a medium-to-short arc length and stringer-beads. Terminate welds either on endblocks and back-whip or use a "side-up technique". Adopt a balanced welding sequence to minimize base metal overheating. De-slag thoroughly.

POST-WELDING: For air-hardening steels, slow cool using available insulating materials. For less-sensitive metals, slow cool out of drafts.

TYPICAL APPLICATIONS

APPLICATIONS	INDUSTRY
• Heat-Treating Trays & Baskets	Forging
• Ingot Tongs	Iron and Steel Works
• Continuous Casting Molds	Foundry
• Merchant Mill Roll Guides	Iron and Steel Works
• LNG Pro. Pumps Liquefied	Natural Gas Plants

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent, Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca

