



Ideal for joining dissimilar steels  
even of varying thicknesses

# **Xuper® NucleoTec® N 2222**



- X-ray quality welds
- Easy to use in all positions
- Ideal for critical welding problems
- High tensile strength (~100,000 psi)
- High crack resistance
- Superior bend strength properties
- Improved impact properties

# Xuper® NucleoTec® N 2222

Xuper NucleoTec N 2222 is a coated electrode specially formulated with a high percentage of nickel, chromium and manganese. Deposits offer an unusual combination of physical properties which include:

- Excellent Corrosion and Oxidation Resistance
- High Ductility
- High Impact Resistance
- Minimum Base Metal Dilution
- Extraordinary Thermal Integrity

## TECHNICAL DATA

### Typical Values

Hardness:	90 HRB
Tensile Strength:	94,000-100,000 psi (650-690 N/mm <sup>2</sup> )
Yield Strength:	56,565 psi (390 N/mm <sup>2</sup> )
Elongation (1=5d):	45%
Impact Strength:	96 ft. lbs. (130J) @ 68°F (20°C)
Current polarity:	DC Reverse
Bend Test Results:	(3 x 90° free-bend tests): Free from fissures and/or cracking

Thick sections, heavy build up	DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
	AMPERAGE	80-90	100-110	120-140	150-170
Thin sections, out of position	DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
	AMPERAGE	50-70	70-90	90-110	110-140

## PROCEDURE FOR USE

Clean weld area. Remove fatigued metal. Hold a medium-short arc. Tilt the electrode in the direction of travel. Deposit stringer beads. At the end of each bead, increase the rate of travel, run electrode off to either side and back whip approximately 45°.

Vertical: Weld from the bottom up with a close arc and 2x weave.

## TYPICAL APPLICATIONS

The ideal solution when welding critical engineering equipment, cryogenic equipment, injection molds, forging tools and dies, gas liquefaction equipment, chemical processing equipment, heat exchange equipment and kiln tires.

### TYPICAL BASE METALS:

- All steels and nickel alloys
- Difficult to weld steels
- Clad steels
- Cryogenic steels
- Mold steels
- Free-machining and specialty steels



**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



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