

Outstanding capacity to join steels not only in dissimilar combinations, but also combinations of dissimilar thicknesses as well

# Xuper<sup>®</sup> NucleoTec<sup>®</sup> 2222



## ELECTRODES

- 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



## DESCRIPTION:

2222 is a XuperLIFE FrigidArc coated electrode. Its a specially formulated alloy with a high percentage of nickel, chromium and manganese. Deposits offer an unusual combination of physical properties which include:

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

## TECHNICAL DATA:

Current: DC Reverse

Tensile Strength : 95,000 psi to 99,700 psi

Yield Strength : 61,600 psi

Elongation (1=5d): 45%

Reduction of Area: 53.2%

Bend Test Results: (3 x 90° free-bend tests): Free from fissures and/or cracking

Diameter [mm] / [in.]	Amperage [A] Range
Thick sections, heavy build up	
3/32"	80-90
1/8"	100-110
5/32"	120-140
3/16"	150-170
Thin sections, out of position	
3/32"	50-70
1/8"	70-90
5/32"	90-110
3/16"	110-140

## TYPICAL BASE METALS:

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

## TYPICAL APPLICATIONS:

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

## WELDING PROCEDURE & TECHNIQUE:

Clean weld area. Remove fatigued metal. Preheat is not necessary unless heavy sections are involved. 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.

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



### Eutectic Corporation

N94 W14355 Garwin Mace Drive  
Menomonee Falls, WI 53051 USA  
P 800-558-8524 • F 262-255-5542  
www.eutecticus.com

### Eutectic Canada

428, rue Aime Vincent  
Vaudreuil-Dorion, Quebec  
J7V 5V5  
Phone: (800) 361-9439  
Fax: (514) 695-8793  
www.eutectic-na.com

### Eutectic Mexico

KM 36.5 Autopista  
Mexico-Quertaro  
54730 Cautitlan-Izcalli  
Estado de Mexico, Mexico  
Phone: 011 (52) 55-5872-1111  
e-mail: eutectic.mexico@eutectic.com.mx

**Statement of Liability:** Due to variations inherent in specific applications, the technical information contained herein, including any information as to suggested product applications or results, is presented without representation or warranty, expressed or implied. Without limitation, there are no warranties of merchantability or of fitness for a particular purpose. Each process and application must be fully evaluated by the user in all respects, including suitability, compliance with applicable law and non-infringement of the rights of others, and Eutectic Corporation and its affiliates shall have no liability in respect thereof.