

XHD 2222

Manual Metal Arc Electrode For Joining Thick Sections Of Hardenable Steels

DESCRIPTION:XHD 2222 is a high-alloy nickel-based electrode designed for critical maintenance and repair applications. It is suitable for a wide range of high alloy steel components, providing maximum repair reliability and extended part service life. The electrode is known for its superior crack resistance and high mechanical properties, ensuring an excellent in-service Maximum Safety Margin (MSM).

Product Details

- Manual Metal Arc Electrode For joining thick sections of hardenable steels

APPLICATIONS

Protective coatings and/or joining: flame hardening equipment, heat treating trays, pipe flanges, barrels, gate valves, hooks, baskets, gas plants, steel mill roll ends, carbon dioxide equipment, guides, tongs, heat treating racks, and related equipment.

Suitable for use on all steel alloys, nickel alloys, and for joining combinations of dissimilar alloys.

PROCEDURE FOR USE

Preparation: Remove fatigued or damaged metal, and grind the surface. For joining, or the repair of cracks in heavy-section parts, make a

«U» groove chamfer with ExoTrode.

Preheating: For the joining or overlaying of high nickel alloys, preheating is not normally required. Preheating will be required for air hardening, higher carbon, and low alloy steels. Particular care should be taken when joining ferritic steels to nickel alloys to avoid overheating the nickel side.

Welding Technique: For heavily-constrained sections, start with a buttering layer on both faces of the chamfer to reduce the effects of dilution by the base metal. Where there is a high risk of producing hardened structures in the base metal, weld the first pass with 2.5 mm electrodes. Fill the chamfer with 3.2 mm or 4 mm diameter electrodes, according to the size of the job, and hammer peen to relieve contraction stresses.

TECHNICAL DATA

Tensile strength : 650 N/mm²(95000 psi) Yield strength : 398 N/mm² (58000 psi)

Elongation: 35%

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.5mm	80-120
3.2mm	100-160
4.0mm	130-200
5.0mm	200-250

Note: For optimum result use the lowest amperage practical