

**AMTEC 222 LOW ALLOY STEEL  
AC/DC REVERSE/STRAIGHT ELECTRODE**

**General Characteristics**

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Amtec 222 is a specially developed, all position, low alloy steel electrode for fabrication and maintenance work. It produces smooth and spatter-free welds, with either AC or DC equipment and can be used as a contact electrode. Its easy slag removal guarantees a minimum of cleanup and finishing. Ideal for field repair work and out of position welding. Amtec 222 produces a deeper penetration when welded on DC Reverse, and a soft low penetrating weld when used on DC Straight. This is ideal when welding on thin sheet metal, where cleanup will be at a minimum.

**Procedure**

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Clean the weld area. Maintain a short arc with the electrode tilted about 15° in the direction of travel. Travel slightly faster than with regular low alloy steel electrodes, using stringer beads. In cases of poor fit-up, weave beads are suggested to permit faster welding without burn through. This electrode is also excellent on dirty steels, welding without porosity.

**Application**

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Amtec 222 is used for general maintenance, repair, and production welding, since it produces spatter free welds. It is ideal for welding ornamental iron, railings, steel furniture, and other applications where painting is required after welding. Excellent for welding thin gauge sheet metal without slag interference. Also excellent on galvanized steel, producing superior welds without a lot of burn back on the galvanizing.

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<b>Tensile Strength</b>	<b>83,000 PSI</b>
<b>Yield Strength</b>	<b>75,000 PSI</b>
<b>Elongation</b>	<b>25%</b>
<b>Impact Strength</b>	<b>90 J: -20°C</b>

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<b>Diameter (Inch)</b>	<b>1/16</b>	<b>5/64</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>
<b>(mm)</b>	<b>1.5</b>	<b>2.0</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>

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<b>Amps (approx.)</b>	<b>20-40</b>	<b>30-50</b>	<b>50-70</b>	<b>70-110</b>	<b>115-140</b>
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**CONFIDENTIAL INFORMATION**  
Subject to change without notice

**Tip Color - White**  
**222 Imprint**