



**AMTEC SUPER 223XC  
MEDIUM CARBON STEEL  
AC/DC REVERSE ELECTRODE**

**General Characteristics**

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**Amtec 223XC is a high strength and highly crack resistant electrode for medium carbon and cast steel. It is an electrode with high elongation, and exceptional qualities for the welding of highly stressed mild steel. It provides a smooth deposit on base metals, and it is free from undercuts with easy manipulation in all positions. Metal recovery is approximately 115%.**

**Procedure**

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**Clean surface contamination from the weld area. Bevel heavy sections. Preheating is not generally required, except on special applications (complicated parts or heavy sections). Maintain a short arc. Allow the slag to remain on the deposit while cooling. When cool, chip slag thoroughly between passes to prevent slag inclusions.**

**Application**

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**Amtec 223 XC is recommended for mining and construction repair work. Use it to join steel frames, boiler plate, crusher parts that are not manganese, and cast steel. It is outstanding for welding steel sensitive to cracking. Excellent on steel that is subject to vibration. Use on tractor frames and the joining or build-up of cast steel.**

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<b>Tensile Strength</b>					<b>85 ,000 PSI</b>
<b>Yield Strength</b>					<b>69,000 PSI</b>
Elongation		34%			
<b>Impact Strength</b>					<b>90J: -30°C</b>

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<b>Diameter (Inch)</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>

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<b>Amps (approx.)</b>	<b>65-100</b>	<b>100-140</b>	<b>140-190</b>	<b>190-250</b>
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**CONFIDENTIAL INFORMATION**  
**Subject to change without notice**

**Tip Color – Blue**  
**Super 223XC imprint**