



## HH 222 EW MILD STEEL AC/DC REVERSE/STRAIGHT ELECTRODE

### General Characteristics

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HH 222 EW 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. It 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 excellent on dirty steels, welding without porosity.

### Application

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HH 222 EW 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 guage sheet metal without slag interference. Also excellent on galvanized steel, producing superior welds without a lot of burn on the galvanizing.

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

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

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Amps (approx.)	20-40	30-50	50-70	70-110	115-140
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