



HH 223 DS

MEDIUM CARBON STEEL

AC/DC REVERSE ELECTRODE

General Characteristics

HH 223 DS 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

Clean surface contaminants 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

HH 223 DS 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.

Tensile Strength	85,000 PSI			
Yield Strength	69,000 PSI			
Elongation	34%			
Impact Strength	90J: -30°C			
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Diameter (Inch)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0
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Amps (approx.)	65-100	100-140	140-190	190-250
