

High Strength and Ductility under Tough Conditions

# Xuper<sup>®</sup> 2222 XHD



## WELDING

- For use with flame-hardening equipment
- Formulated for high speed welding of critically stressed applications
- Excellent for high temperature and sub-zero cryogenic applications



## DESCRIPTION

Xuper 2222XHD is a nickel-based electrode formulated for high-speed, high-deposition welding of critically stressed applications. Deposits exhibit superior crack resistance and ductility. This easily handled electrode is ideal for welding large cross sections in a variety of steels where cool-down stresses can be a problem. Xuper 2222XHD maintains a high-tensile strength at high temperatures (1200°F) as well as in cryogenic applications.

## WELDING PROCEDURE & TECHNIQUE

**Preparation:** Remove all contaminants, particularly oil and grease. Lightly grind surface to remove superficial oxides. Preheating is not necessary unless the part has a large cross-section or has high air hardenability. In these situations preheating within a range of 250°-300°F (121°-149°C) is advised.

**Technique:** Always use the lowest practical amperage range to minimize dilution. Use a medium-to-short arc length and stringer-beads. Terminate welds either on end-blocks and back-whip or use a "side-up technique". Adopt a balanced welding sequence to minimize base metal over-heating. De-slag thoroughly.

**Post-Welding:** For air-hardening steels, slow cool using available insulating materials. For less-sensitive metals, slow cool out of drafts.

## TYPICAL ANTI-WEAR APPLICATIONS & INDUSTRIES

### APPLICATIONS

- Heat-Treating Trays & Baskets
- Ingot Tongs
- Continuous Casting Molds
- Merchant Mill Roll Guides
- LNG Processing Pumps

### INDUSTRY

- Forging
- Iron and Steel Works
- Casting of Metals
- Iron and Steel Works
- Liquefied Natural Gas Plants

## XUPER 2222XHD TECHNICAL DATA & SET-UP INFORMATION

Typical Tensile Strength: 90,000 psi (620 N/mm<sup>2</sup>)  
Typical Yield Strength: 65,000 psi (450 N/mm<sup>2</sup>)  
Typical Elongation (1=5d) min.: 42%  
Typical Hardness: BHN: 180

Diameter [mm] / [in.]		Amperage [A] Range
2.4	3/32	80 - 120
3.2	1/8	110 - 160
4.0	5/32	150 - 190

Note: When welding with Xuper 2222XHD make sure to remove ALL sources of sulfur, often an ingredient in both oils and greases.



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