



223XC®

GENERAL CHARACTERISTICS:

ARCTEC® 223XC® is a high strength and highly crack resistant electrode for welding of medium carbon and cast steel. Has very good ability to withstand deformation in rigid structures where high welding stresses exists. Has excellent welding characteristics in all positions and produces sound crack free deposits. Metal recovery is approximately 115%.

APPLICATIONS:

ARCTEC® 223XC® is recommended for repair welding of a wide range of mining and construction equipment, for joining of steel frames, crusher parts and cast steel components. Outstanding for welding steels sensitive to cracking. Also suitable for buildup and repair of steel castings.

WELDING PROCEDURE:

Clean surface contaminants from weld area. By observing good welding practices and electrode care associated with low hydrogen electrodes and taking into consideration heat input and the control of hydrogen, by maintaining a short arc length in the welding process, excellent results can be consistently attained. To meet impact strength requirements, preheat and post heat may be recommended on heavier sections to reduce hardness and control stress in the weld area which will further enhance the weld deposits resistance to underbead cracking.

MECHANICAL PROPERTIES:

| Tensile Strength | Yield Strength | Elongation | ft/lbs | Impact Strength | Temperature |
|-------------------|-------------------|------------|---------|-----------------|-------------|
| 80,000-85,000 psi | 65,000-77,000 psi | 28%34% -2" | 150-173 | Joules | -40°C |
| 555-590 MPa | 450-535 MPa | | 55-62 | 203-234 | |
| | | | | 75-84 | |

WELDING PROCESS: SMAW / POLARITY: DC REVERSE or AC / Hardness 40-55 HB / Tensile Strength 34,000 PSI / Elongation 15% -25% 2"

| | | | | | |
|------------------|---------------|----------------|----------------|----------------|----------------|
| DIAMETER: | 3/32" | 1/8" | 5/32" | 3/16" | 1/4" |
| AMPERAGE: | 80-100 | 120-140 | 150-180 | 200-250 | 280-340 |



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