

# spark 1220 AS

WELDING ELECTRODES

## Electrodes for joining dissimilar and unknown steels

### Description:

Spark 1220 AS is a low heat high tensile electrode which has very high strength and ductility with excellent moderate wear and high impact resistance. The electrode is used for similar as well as dissimilar steel welding and has a high, excellent resistance to cracking and oxidation. In high alloy steels, the electrode can be used for depositing a buffer layer, acting as a shock absorbent. The grain refining agents used in the electrode impart high resistance to hot cracking in the weld.

### Applications:

- For dissimilar joints between carbon, high alloy and heat resistant steels.
- For joining low and high alloy steels.

### Welding Parameters: Current: AC 70, DC+/-

Size (mm x mm)	Current (Amps)
3.15 x 350	55 – 90
4 x 350	80 – 135
5 x 350	110 -165

### Typical Mechanical Properties

U.T.S.	770 MPa
Proof Stress	0.2%
%E	24
Impact	27 Joules at - 51°C





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