

SelectAlloy 2216-C

Description:

SelectAlloy 2216-C is a metal cored electrode designed for the welding of high strength cast irons and for the welding of dissimilar joints between cast irons and steel. It is designed for use with argon/1-2% oxygen, but may also be used with argon/20-25% CO₂ shielding gas.

Classification:

- ECNiFeMn-C1 per AWS A5.15

Characteristics:

SelectAlloy 2216-C deposits a smooth, highly crack resistant weld bead. It produces little or no slag with low spatter, minimizing cleanup. It offers higher deposition rates and more controlled penetration than the equivalent solid electrode. As a result it operates at higher travel speeds and handles poor fit-up.

Applications:

SelectAlloy 2216-C is used for welding cast iron parts to dissimilar steels found in automotive exhaust systems. It may also be used for buildup or repair welding of ductile, malleable or gray cast iron.

Typical Mechanical Properties

Ultimate Tensile Strength (psi)	95,000
Yield Strength (psi)	68,000
Percent Elongation	15

Typical Chemistry:

<u>C</u>	<u>Mn</u>	<u>Ni</u>	<u>Fe</u>
0.40	11.80	41.0	Bal.

Operating Range:

	<u>WFS (ipm)</u>	<u>Amperage</u>	<u>Voltage</u>	<u>ESO (in.)</u>
Ar-2% O ₂	260-450	165-240	25-28	5/8
Ar-25% CO ₂	265-450	175-230	29-32	5/8

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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.