

Technical Data Sheet

7220 Tubular Electrode



Cronatron™
A LAWSON BRAND



Overview

A Hardsurfacing Electrode Combining Chromium Carbides with Tungsten Carbides

7220 Tubular Electrode is a uniquely formulated, tubular, hardsurfacing electrode that combines the high carbon, high chromium of a conventional chromium carbide deposit with tungsten to yield the hardest complex carbide structure available in an extremely fine tool-steel-type matrix. This enhanced deposit provides the ultimate in abrasion resistance on carbon and low-alloy-steel base metals.

Features/Benefits

- Ultra-fine tool steel matrix microstructure with tungsten and chromium carbides
- Unprecedented abrasive wear resistance
- The 1/4" (0.64cm) dia. is designed to use in all positions, including vertical and overhead
- Water-resistant flux coating
- Little or no spatter
- Low fume generation

Applications

- Drill collars
- Scrapers
- Feed screws
- Screw flights
- Chutes
- Asphalt mixer paddles

Method of Application

AC or DC reverse polarity

Identification

Gray Tip, black electrode

Directions for Use

Remove any cracked or spalled material before welding. Use AC or DC reverse polarity. Hold a short arc with a two pass maximum deposit.

Technical Specifications

Hardness (2nd Pass): Rc 68

Technical Tips

Relief checks are normal; finish by grinding if necessary. **Do not use on manganese steel. Not recommended for impact.** Maximum of two passes is recommended.

