

Technical Data Sheet

7222A Tubular Electrode



Cronatron™
A LAWSON BRAND



Overview

Exclusive, Patented Extreme-Abrasion Alloy

7222A Tubular Electrode is a tungsten-carbide alloy designed to combat the most extreme abrasive-wear problems.



Features/Benefits

- Highest tungsten carbide content available
- Multiple size tungsten-carbides compressed in tubular steel provide consistent deposit density
- Multi-alloy system provides wettability with base metal as well as with tungsten-carbide particles
- Reseals automatically – carbides do not fall out
- All position, low amperage
- Minimal slag coverage
- Little or no spatter
- Faster application and less heat input than with gas-applied rod

Applications

- Augers
- Skid pads
- Plowshares
- Dry cement screws
- Screw flights
- Farm implements

Method of Application

AC or DC straight polarity

Identification

Flux-coated, brown-tipped black electrode

Directions for Use

Clean base metal, large sections may require preheat. Use AC or DCSP 85A to 110A. Low-amperage setting minimizes base-metal dilution. Stringer bead or slight weave technique is recommended. Do not use on manganese steel.

Technical Specifications

Hardness (2nd Pass): Rc 65

Technical Tips

A tight arc reduces heat input and improves deposit properties.

