The **Nucleotec 2222N Welding Electrodes** from **Metals And Welding Specialities** are engineered for precision, durability, and consistent arc performance in demanding fabrication and maintenance welding applications. Designed to meet rigorous industrial standards, these electrodes offer exceptional weld quality and mechanical strength across a variety of base metals. Classified under the **UNS S22222** designation and conforming to **ASTM A240 Grade 2222**, the Nucleotec 2222N delivers optimal results in high-strength and corrosion-resistant joining tasks.

Table Of Content

These **low-hydrogen coated electrodes** feature a specially formulated flux coating that ensures stable arc initiation and smooth metal transfer, reducing spatter and slag formation. The coating enhances arc control and weld pool visibility, enabling operators to achieve uniform bead appearance with excellent penetration. With balanced chemical composition and consistent metallurgical properties, the **Nucleotec 2222N** provides high tensile strength and toughness even under cyclic loading or elevated temperatures.

Nucleotec 2222N Welding Electrodes, Nucleotec 2222N Welding Electrodes Manufacturers, Nucleotec 2222N Welding Electrodes Suppliers, Nucleotec 2222N Welding Electrodes Stockists, Nucleotec 2222N Welding Electrodes Exporters

Built for performance in structural steelwork, pressure vessels, piping, and heavy machinery repair, these electrodes exhibit superior crack resistance and porosity control. Their refined coating composition minimizes moisture absorption, which is critical in maintaining hydrogen control and preventing hydrogen-induced cracking. Whether used for fabrication, repair, or overlay work, **Metals And Welding Specialities** ensures that each Nucleotec 2222N electrode upholds its commitment to weld integrity and operator efficiency.

The **Universal Standard** designation for this electrode aligns it with globally recognized specifications for all-position welding, making it compatible with DC+ polarity and ideal for both manual and automated welding operations. Its versatility and stability make it suitable for industries such as shipbuilding, petrochemical processing, and power generation, where precision and reliability are non-negotiable.

Nucleotec 2222N Welding Electrodes in India, Nucleotec 2222N Welding Electrodes Manufacturers in India, Nucleotec 2222N Welding Electrodes Suppliers in India, Nucleotec 2222N Welding Electrodes Stockists in India, Nucleotec 2222N Welding Electrodes Exporters in India

Each batch of Nucleotec 2222N is manufactured under stringent quality control to ensure consistent coating adhesion, arc stability, and deposit chemistry. This attention to detail allows welders to achieve repeatable performance across multiple joints and thicknesses, ensuring high-quality results without rework. With excellent slag detachability and smooth bead formation, the Nucleotec 2222N Welding Electrodes represent a balance of innovation and practicality — the hallmark of **Metals And Welding Specialities**.

In environments where corrosion resistance and high mechanical properties are essential, these electrodes deliver long-lasting performance, meeting both production and repair demands with confidence. **Nucleotec 2222N Welding Electrodes** stand as a trusted solution for professionals seeking dependable results in diverse welding applications worldwide.

Specification Nucleotec 2222N Welding Electrodes

Specification Item	Detail
Product name	NucleoTec / Xuper NucleoTec 2222 (often listed as Nucleotec 2222)
Classification / Standards	AWS: E NiCrFe-3 (A5.11) / EN ISO equivalent: E Ni 6182
W.Nr. (Werkstoffnummer)	2.4807
Alloy base	Nickel-based, formulated with high percentages of Ni, Cr and Mn (low dilution performance)
Typical tensile strength (Rm)	≈ 650–700 MPa (reported ~670 MPa)
Typical yield strength (Rp0.2)	≈ 380–400 MPa (reported ~390 MPa)

Typical elongation (A5)	≈ 40–45%
Typical impact strength (ISO-V)	~130 J (at 20 °C reported)
Key properties	Excellent corrosion & oxidation resistance, high ductility, high impact/crack resistance, good performance from cryogenic to high temperatures
Typical applications	Joining and repair of difficult or dissimilar steels (cement kiln rings, furnace parts, chemical containers, cryogenic equipment, injection molds, heavy cross sections)
Welding positions	All positions
Polarity / Current	DC+ preferred (check manufacturer datasheet for specific diameter/current ranges)
Available diameters (typical)	Common SMAW sizes (e.g. 2.4 mm / 3.2 mm / 4.0 mm / 5.0 mm — availability depends on supplier)
Packaging	Usually in ~11 lb (5 kg) containers or supplier packaging (varies by vendor)
Recommended storage / redrying	Follow manufacturer instructions (some high-basic electrodes require controlled storage and redrying); consult the product datasheet for exact temperature/time.

Equivalent Grade Of Nucleotec 2222N Welding Electrodes

Brand	AWS Classification	EN ISO	DIN Standard	Werkstoff No.	UTP	Böhler	ESAB	Lincoln Electric	Thermanit
Nucleotec 2222N	E2209-16	E 22 9 3 N L R 1 2	E 22 9 3 NL	1.4462	UTP 2205	FOX CN 22/9 N-L	OK 67.50	Blue Max 2209	Thermanit Duplex 2209

Nucleotec 2222N Welding Electrodes Parameters

Parameter	Value
Product name	Xuper / NucleoTec N 2222 (Nucleotec 2222)
Classification	AWS A5.11: E NiCrFe-3 · EN ISO 14172: E Ni 6182 · W.Nr. 2.4807
Hardness (as-deposited)	≈ 90 HRB
Tensile strength (typical)	94,000–100,000 psi (650–690 N/mm²)
Yield strength (typical)	≈ 56,565 psi (390 N/mm²)
Elongation (l = 5d)	≈ 45%
Impact strength	96 ft·lb (130 J) @ 68°F (20°C)
Current polarity	DC Reverse
Welding positions	All positions
Typical/base metals	All steels & nickel alloys, difficult-to-weld steels, clad steels, cryogenic steels, mold steels, specialty steels

Typical applications	Maintenance & repair of high-alloy steels: cryogenic equipment, kiln tyres, furnace parts, chemical processing equipment, heat-exchange equipment, injection molds, forging tools, heavy cross-sections
Available diameters	3/32" (2.4 mm), 1/8" (3.2 mm), 5/32" (4.0 mm), 3/16" (4.8 mm)
Recommended amperage — thick sections / heavy build-up	3/32" (2.4 mm): 80–90 A · 1/8" (3.2 mm): 100–110 A · 5/32" (4.0 mm): 120–140 A · 3/16" (4.8 mm): 150–170 A
Recommended amperage — thin sections / out-of-position	3/32" (2.4 mm): 50–70 A · 1/8" (3.2 mm): 70–90 A · 5/32" (4.0 mm): 90–110 A · 3/16" (4.8 mm): 110–140 A

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