

**155 B****CAST IRON****DESCRIPTION**

General purpose bare rod for **assembling** and **rebuilding** grey and/or malleable cast iron parts **with a torch**. Excellent for cast iron-steel dissimilar assemblies.

CHARACTERISTICS

- **Ideal for welding thin sections**
- Dense and porosity-free deposit
- Can be used in position
- Machinable deposit
- Excellent color match with base metal
- No other soldering flux required

TYPICAL APPLICATIONS

Aluminized steels exhaust manifolds, machinery bases, gear teeth, motor units, molds, pump housings, aluminized muffler pipes; rebuilding of used or missing sections, porosity fill, foundry defects, cast iron antique parts, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the weld surface. Gouge the thick sections and the cracks with **Soudotec 212 SP**. Preheat the welding area evenly to about 427°C (800°F). Use the flux F0155 with a slightly oxidizing flame, heat the rod tip to generate a liquid flux on the work piece. Melt the filler metal one droplet at a time and spread on the bottom of the joint while moving the flame back and forth. Cool slowly.

MECHANICAL PROPERTIES

Tensile strength: 45 000 psi (310 MPa)
Hardness: 200 - 250 BH

WELDING PARAMETERS

Diameter: 5.0 mm (3/16") 4.0 mm (5/32")
Bonding temperature: 760 – 871°C (1400 – 1600°F)
Type of flame: Slightly oxidizing

Rev.: 21_08

Specialized welding alloys and technology. For technical assistance or for ordering: