

**165**

AC/DC+

CAST IRON**DESCRIPTION**

Specially coated electrode with **copper-clad ferro-nickel core** for cold welding and building up of grey cast iron, malleable cast iron, spheroidal cast iron, etc. **Excellent for steel to cast iron assemblies.**

CHARACTERISTICS

- **Exceptional resistance to overheat due to copper-clad core**
- Very high melting rate at low amperage
- Excellent weldability in all positions, without preheat
- Machinable, crack-resistant deposits
- Excellent on AC/DC power supply
- Good wash-in and flow of the weld metal

TYPICAL APPLICATIONS

Cast iron parts for industrial machinery, the automobile industry, steel industry, paper industry, mining industry, etc.; pumps, fittings, valves, motor units, cylinders, crankcases, molded parts, etc.

PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. Remove cracks with **Soudotec 212 SP** or **Soudotec G12** electrode. Use hot or cold welding technique (p.01-02 and 01-03). Maintain a short arc and peen while still hot between each pass to stress relieve. Cool slowly.

MECHANICAL PROPERTIES

Tensile strength: 75 000 psi (517 MPa)
Hardness: 200 BH

WELDING PARAMETERS

Diameter:	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	70 - 100 A	50 - 70 A

Rev.: 21_08

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