



168

AC/DC+

CAST IRON

### DESCRIPTION

**Specially-coated** electrode with a **low-carbon steel core** designed for **cost-effective** welding of dirty, contaminated and burnt cast irons. **Excellent for depositing buttering coats** before welding with machinable cast-iron electrodes.

### CHARACTERISTICS

- **Excellent all-position weldability on any quality cast iron**
- Good anchorage on dirty and oily cast irons
- Excellent on AC power supply
- Rust deposits with good color match on cast irons
- Good mechanical resistance
- Machinable deposits by grinding only

### TYPICAL APPLICATIONS

Foundry oven parts, sewer pipes, exhaust manifolds, smelting irons, oil and grease-saturated cast parts, oven racks, crankcases, farm machinery parts, etc.

### PROCEDURE

Clean weld area removing oil, dirt and all impurities. Bevel with **Soudotec 212 SP** or **Soudotec G12**. Use hot or cold welding technique (p.01-02 and 01-03). Keep a short arc. Peen each bead for stress relief. Let cool down slowly.

### MECHANICAL PROPERTIES

Tensile strength: 65 000 psi (450 MPa)  
Hardness: 350 - 400 BH

### WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	100 – 140 A	75 – 110 A

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