

**169 BF****AC/DC±****CAST IRON****DESCRIPTION**

Electrode with high nickel content, **barium free**, recommended for cold welding of all types of cast irons where **watertightness** and/or **100% machinability** are required. The coated is non-conductive.

**CHARACTERISTICS**

- **Ideal for thin cast iron sections**
- **Non-conductive coating**
- High ductility and low sensitivity to cracking
- Low heat input, no preheat necessary
- All-position electrode, excellent on AC power supply
- Very stable arc and spatter-free
- Good bead appearance

**TYPICAL APPLICATIONS**

Recommended for cold welding of cast irons of thin to average thickness, dissimilar assemblies (cast iron/steel), engine blocks, cylinder heads, sleeves, machining errors, gear boxes. 100% machinability.

**PROCEDURE**

Remove any trace of oil, grease and/or dirt from the surface. Remove cracks with a **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: 350 MPa (50 000 psi)  
Hardness: 160 BH

**WELDING PARAMETERS**

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	90 – 130	80 - 105	50 - 90

Also available in solid MIG wire: **Soudotec M8169 SP** and TIG rods: **Soudotec T169**

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