



179

AC/DC+

CAST IRON

DESCRIPTION

Specially-coated electrode with **very high nickel content** and **non-conductive flux coating** recommended for cold welding of all types of cast irons, even when **dirty and/or oily**, where **watertightness** and/or **100% machinability** are required.

CHARACTERISTICS

- Specially designed for welding on dirty and/or oily cast iron parts
- Prevent side-arcing when welding in close quarters
- Ideal for thin cast iron repairs
- Low heat input, no preheat necessary
- All-position electrode, excellent on AC power supply
- Very strong and stable arc

TYPICAL APPLICATIONS

Recommended for cold welding of all types of cast irons (grey, nodular, malleable, etc.) of thin to average thickness, dissimilar assemblies (cast iron/steel), engine blocks, cylinder heads, sleeves, machining errors, gear boxes, pump casing, etc. **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: 55 000 psi (380 MPa)
Hardness: 150 BH

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	100 - 150 A	70 - 120 A	40 - 80 A

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