


Soudotec 189 SP/189 BF AC/DC+
CAST IRON**DESCRIPTION**

Unique steel coated nickel core electrode for easy welding of cast iron to steel, as well as unknown and European cast irons and those with dirty and/or oily surfaces. The **BF** version is **barium free** and the coating is non-conductive.

CHARACTERISTICS

- **Maximum resistance to cracking**
- Low heat input; the electrode will not overheat
- Cold welding in all positions, without preheat
- Dense and porosity-free deposits
- Machinable deposits
- Easy slag removal
- Excellent conductivity

TYPICAL APPLICATIONS

Assembly and repair of all types of cast irons, thick sections and dissimilar cast iron/steel assemblies, machinery bases, presses, gear boxes, compressors, cast iron molds, gear teeth, etc.

PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. Remove cracks with a **Soudotec 212 SP** or **Soudotec G12** electrode. For better results on thick sections, preheat at 120 °C (250 °F) is recommended. 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: 70 000 psi (483 MPa)
Hardness: 180 BH

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	110 - 145 A	90 - 115 A	75 - 100 A

Also available in flux-cored wire MCAW: **Soudotec MC 8189G**

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