

**Soudotec 60**

AC/DC+

**CAST IRON****DESCRIPTION**

**Economical** ferro-nickel type electrode (Ni 60) for joining grey, malleable, nodular and highly solicited cast iron. Recommended for welding dissimilar assemblies between cast iron and steel. Excellent on dirty and oily cast iron.

**CHARACTERISTICS**

- **High cracking resistance and homogeneous deposit**
- Excellent anchorage of deposited metal
- All position weldability
- Hardly machinable deposit
- Conform to standard AWS A5.15 : ENiFe-CI

**TYPICAL APPLICATIONS**

Engine blocks, agricultural equipment, high thickness parts, pump housings, foundry defaults, cast parts, etc.

**PROCEDURE**

Clean weld area removing 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. Do not wave. Peen each bead for stress relief. Let cool slowly.

**MECHANICAL PROPERTIES**

Tensile strength: 65 000 psi (450 MPa)  
Hardness: 200 BH

**WELDING PARAMETERS**

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	120 - 150 A	90 - 110 A	50 - 80 A

Rev.: 21\_08

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