


M8169 SP DC+
CAST IRON**DESCRIPTION**

Solid GMAW (MIG) wire with a **unique formula** for **building up** and **assembling** different types of cast irons such as malleable, nodular and grey cast iron. Excellent for cast iron to steel dissimilar assemblies.

CHARACTERISTICS

- **Excellent machinability (100%)**
- No undercut with minimum dilution rate
- Very good bead appearance
- Excellent arc stability

TYPICAL APPLICATIONS

Thick cast iron parts, smelting parts, shafts, housings, frames, turbines, pulp and paper industry, etc.

PROCEDURE

Clean the workpiece and chamfer with **Soudotec G12** or **Soudotec 212 SP**, if needed. Deposit a stringer bead with a slight weaving motion. Peen the beads to reduce tension and fill all craters at the beginning and end of each pass, if necessary. Preheating between 200 - 260 °C (400 - 500 °F) is recommended for thick cast iron parts. Use hot or cold welding technique (p.01-02 and 01-03).

MECHANICAL PROPERTIES

Tensile strength: 60 000 psi (414 MPa)
Hardness: 100 – 150 BH

WELDING PARAMETERS

Gas: 75 % Argon / 25 % CO₂
Diameter: .045" (1.2 mm)
Amperage: 125 - 160 A
Voltage: 16 - 20 V
Stick-out: 3/8" - 3/4"
Gas flowrate (c.f.h) 40 - 50
Packaging: 2.3 kg (5 lb), 5 kg (11 lb) or 11.4 kg (25 lb) spool

Also available in electrodes: **Soudotec 169 BF** and TIG rods: **Soudotec T169**

Rev.: 21_08

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