


**MC 8189G DC+**
**CAST IRON**

### DESCRIPTION

**Gas shielded** Metal-cored wire **without slag** with a special ferro-nickel formulation for **joining, building up** and **repairing** a large variety of cast iron. Excellent for cast iron and steel dissimilar assemblies.

### CHARACTERISTICS

- **Excellent weldability and arc stability**
- Dense and machinable deposit (with carbide tools)
- Excellent mechanical properties
- No slag to remove
- Good bead appearance
- Excellent for thick cast iron parts and for different thickness parts
- High deposit rate

### TYPICAL APPLICATIONS

Cast iron and steel dissimilar assemblies, thick cast iron parts, housings, smelting parts, press, gear teeth, machinery bases, cast iron molds, etc.

### PROCEDURE

Clean the work piece and chamfer with **Soudotec G12** or **Soudotec 212 SP**, if needed. Maintain a short arc and deposit a stringer. 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: 80 000 psi (550 MPa)  
Hardness: 180 BH

### WELDING PARAMETERS

Gas: Argon - CO<sub>2</sub> mixture  
Diameter: .045" (1.2 mm) (others diameters on request)  
Amperage: 180 - 250 A  
Voltage: 20 - 26 V  
Stick-out: 1/2" - 1"  
Gas flowrate (c.f.h): 40 - 50  
Packaging: 2.3 kg (5 lb), 5 kg (11 lb) and 15 kg (33 lb) spool

Also available in electrodes: **Soudotec 189 SP/BF**

Rev. : 21\_08

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