

FILLER METAL SELECTION TABLE FOR CAST IRON WELDING

PRODUCTS	155 B	160	165	168	169 BF * MG169 SP	179	189 SP/BF * MC 8189G
PROPERTIES							
Tensile strength (x 1000 psi)	45	65	75	65	50 (* 60)	55	70 (* 80)
Hardness (BH)	200 - 250	190	200	350 - 400	160 (*150)	150	180 (*180)
Burnt cast iron	1			1			
Oily cast iron		2	3	2		1	1
Thick cast iron		3	2				1
Thin cast iron	1				1	1	
European cast iron		3	2				1
Unknown cast iron		2	3		1	2	1
Cast iron to steel assemblies	1	3	2	3	3	2	1
Machinability	1	3	3		1	1	3
Anchorage				1			
Machining errors	1	3	3		1	2	3
Buttering coats before welding		2	2	1	1	1	2
Exhaust manifolds	1	3	3	1			2
Motor units		2	2		3	2	1
Pulleys and gears	1	2	3				1
Housings and pump housings	1	2	2			1	1
Cast iron molds		3	3		1		1
Sewer pipes		3	3	1		1	2
Foundry oven parts		3	3	1			2

1 = Most efficient product(s)

Note:

This table is not exhaustive; other products may be suitable for certain applications and/or characteristics. Consult the **FSH Welding Canada** Technical Department.