CPCI 026 ac / dc-

Rear Axle

An excellent electrode for repair of casting defects

Typical Applications:

Foundry defects, machine build up.

Outstanding Features:

- Excellent operating characteristics.
- Dense deposits with good bonding.
- Optimum machinability.
- Stronger than conventional nickel-based cast iron welding alloys.

Recommendation:

Weld repair of foundry defects such as blow holes, shrinkage, cavities, missing sections etc, where a sound machinable deposit is essential. Also for rectification of machining errors and for building up worn out areas of cast iron parts.

Procedure:

Clean weld area. Drill holes at ends of cracks and Vee out using Eutec-ChamferTrode. Preheating is normally not required but may be employed upto 150°C for better machinability. Using minimum current and maintaining short arc gap, deposit stringer beads 25 to 75 mm long at a time. Back-whip craters. Peen each bead after deposition. Remove slag between passes.

Recommended Amperages:

Size (mm)	Amperage
4.00	85 - 110
3.15	60 - 85
2.5	50 - 60

Tensiles Strength: 42 Kg/mm^2
(60,000 psi)