



An Excellent Electrode for Weld Repair of Cast Iron

Typical Applications:

Repair of Casting Defects, Machine Build-Up, Foundry Defects, Pump Body, Motor Base, Coupling.

Outstanding Features:

- Dense deposits with good bonding
- Optimum machinability
- Excellent operating characteristics

Recommendations:

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 build-up of worn-out areas of cast iron parts.

Procedure:

Clean weld area. Drill holes at ends of cracks and vee out using Eutec ChamferTrode. Preheat 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. Whip-back craters. Peen each bead after deposition. Remove slag between passes.

Tensile Strength (Typical):

410 MPa (59,000 psi)

Recommended Amperages:

Size (mm)	2.50	3.15	4.00
Amperages	50-70	80-100	100-120