# Terra CI 94 AC/DC-



# 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 wornout 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



### **EWAC Alloys Limited**

(A wholly owned subsidiary of Larsen & Toubro Limited)

#### Marketing Office:

L&T Business Park, TC - II, Tower-B, 5th Floor, Gate No. 5, Powai Campus, Saki Vihar Road, Powai, Mumbai - 400 072, INDIA Tel: + 91 22 6705 2502 / 2983 | Fax: +91 22 6705 1751 E-mail: ewac@larsentoubro.com | Website: www.ewacalloys.com CIN: U74999MH1962PLC012315