Xuper 22*33N ac / dc+

Cylinder Head

Electrode designed with innovative core wire offers good weldability, high tensile strength, ductility and machinability

Typical Applications:

Machine tool bases, valve body, pumps, gear boxes, gear teeth, couplings, piping, transmission housing etc.

Outstanding Features:

- Dense deposits with excellent machinability.
- High tensile strength and high ductility ensure maximum safety margin.
- Wide range of base metal (CI) compatibility.
- Special core wire and flux coating permits consistent, porosity free welding.
- Excellent tolerance to impurities.

Recommendation:

Joining of cast iron and cast iron to steel of similar / dissimilar thicknesses. Repair welding of high strength, heavy duty ductile irons involving massive section and for joints under restraints.

Procedure:

Clean weld area. Drill holes on the starting and end of cracks. Remove damaged metal using Eutec-Chemfer Trode electrode. In most cases part should be welded cold (maximum inter-pass temp 60^{0}C). For complicated parts preheat to at least 300^{0}C. Using short arc at lowest amperage, deposit stringer bead with skip welding. Chip slag with wire brush and peen each deposit.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	90 - 100	70 - 80
3.15	110 - 120	90 - 100
4.00	145 - 160	120 - 135

Tensile Strength: 50 Kg/mm^2
(72,000 psi)

Hardness: 85-95 HRb (3 layer)