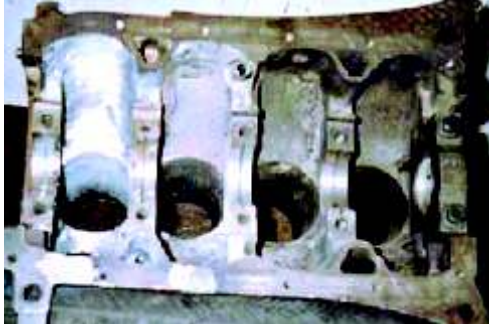


Xuper Xyron[®] 242 ac / dc-



Engine Block

A high nickel electrode for repairing gray cast iron and joining casting to steel

Typical Applications:

Pump housings, pump rotors, compressors, valves, gear boxes.

Outstanding Features:

- Controlled penetration.
- High nickel electrode with specially formulated "Frigid Arc" coating.
- Ideal for critical parts repair

Recommendation:

For repair of gray cast iron and for joining it to other metals. For applications where better machinability required. An all position electrode enabling maintenance work in-situ. "Frigid Arc" coating controls penetration and prevents excessive base metal dilution.

Procedure:

Vee out cracks with Eutec-ChamferTrode. Use ac or dc negative. Clean weld area. Preheat to 100°C to 150°C where better machinability is required. Maintain a short to medium arc at low amperage. Deposit short stringer beads 25 to 75 mm in length. Back-whip each crater. Peen lightly to remove stresses. Chip slag between passes.

Recommended Amperages:

Size (mm)	I - Range	II - Range
4.00	120 - 135	90 - 110
3.15	95 - 110	65 - 85
2.5	60 - 70	35 - 50

Tensile Strength: 35 Kg/mm²
(50,000 psi)