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HIGH RESISTANCE ECONOMICAL WELDING ROD. FILLER METAL CANNOT BE MACHINED. FOR FATIGUED CAST IRON AND FOR CAST IRON CONTAMINATED WITH DIRT OR GREASE.

CLASSIFICATION: A.W.S: E-St

APPLICATIONS: To weld extremely dirty or grease soaked cast parts. To repair motor casings, machinery foundations, cams, and tilling machinery parts. It is used to clad parts before the application of machinable welding like the one obtained with Niqel-Arc electrodes. In general, it can be used in all kinds of repairs with cast iron when machining the filler metal deposit is not indispensable.

CHARACTERISTICS AND PROCEDURE: This is an economical welding rod which produces highly resistant welds on cast iron wherever machining the filler metal is not possible. It can be used in all welding positions. Clean the joint area to remove dirt, scales, grease and rust. To weld parts with thick walls, it is necessary to chamfer cracks into a "V" or a "W" at 90°. To limit crack expansion, drill the crack ends. As a rule, preheating the parts is not necessary. Weld beads should be short and well spaced to evenly distribute the heat as much as possible. Use the lowest possible AMP and keep the arc short. When using DC, connect the electrode holder to the positive pole (reverse polarity). Hammering the weld beads slightly will help to reduce cracks to a minimum. Once you finish welding, let the part cool down slowly by covering it with asbestos or lime.

FILLER METAL CHEMICAL ANALYSIS %					SIZES	AMPERAGE
C	Mn	P	S	Si		
0.06	1.07	0.03	0.03	0.53	2.25 mm - 3/32"	70
					3.25 mm - 1/8"	110
					4.0 mm - 5/32"	140
					5.0 mm - 3/16"	160