



Motor Casing

## Innovative alloy with strong arc force and cleaning action for contaminated cast irons

### Typical Applications:

Contaminated cast irons, cast Iron defects, cast Iron furnace equipment sealing all-soaked cast Iron parts.

### Outstanding Features:

- Nickel-free deposits.
- Spray type of metal transfer.
- High tolerance to impurities.
- Excellent colour match to gray cast iron.

### Recommendation:

Non-conductive coating prevents side arcing; greatly aids welding in tight corners and deep holes. Used as a buffer layer on all cast irons. Exceptional performance on contaminated surfaces. Deposits exhibit colour match on cast irons.

### Procedure:

Clean weld area, drill holes at the starting and end of crack on Cast Irons. Use EWAC GougeTec electrode for preparing U-groove. Deposits offer spray type of metal transfer. The welding alloy should be deposited on base metal with the electrode tilted slightly in the direction of travel. Do not weave. Use short beads not exceeding 30 mm, back whip crater. Remove slag by chipping and brushing.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	105 - 125	70 - 95
4.00	130 - 150	95 - 120

**Hardness:** 40-50 HRc (3 layer)