



Nodular Iron Casting - Cylinder Head

For joining steel to Cast Iron & rebuilding of nodular and alloyed cast irons

Typical Applications:

Nodular iron casting, housing, foundry defects, pump casings, high strength alloyed cast iron gear boxes, machine bases, cast iron die cladding and build up etc.

Outstanding Features:

- Ideal for joining cast iron to steel.
- Deposits having high crack-resistivity due to Nodular deposits.
- Exceptional weldability on thick cross sections.
- Excellent machinability.

Recommendation:

For superior penetration on contaminated surfaces of all ductile iron such as nodular and malleable, as well as joining of gray cast iron to steel. Fully machinable deposit, recommended for crack resistant joining, overlaying, built up and filling porosity.

Procedure:

Remove cracks with EWAC GougeTec electrode. Drill holes at the starting and end of the cracks. Deposit weld metal directly on job. Use skip welding on complicated sections. Maintain interpass temperature of 100°C. Chip slag between passes and peen deposits. Fill crater at end of each pass. Cover the component and allow slow cool.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	80-90	60-70
3.15	105-115	85-95
4.00	130-140	110-120
5.00	155-170	125-145

Tensile Strength: 400 MPa (58, 000 Psi)

Hardness: 80-90 HRb (3 layer)