



Mill Yoke

## 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 EWAC GougeTec electrode. In most cases part should be welded cold (maximum inter-pass temp 60°C). For complicated parts preheat to at least 300°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:** 500 MPa (72,000 psi)

**Hardness:** 85-95 HRb (3 layer)