



Gear Box Casing

## Versatile electrode for welding of heavy sections and crack sensitive applications

### Typical Applications:

Machine bases, pumps and differential housings, cast iron dies

### Outstanding Features:

- Excellent weldability.
- For heavy cast iron sections.
- Machinable deposits.
- For joints subject to hydrostatic pressure.

### Recommendation:

For crack-sensitive applications such as castings involving hydrostatic pressure, joints under restraint, dissimilar thicknesses and the general welding of very heavy sections. Excellent for joining cast iron to steel. Circumferential pipe welds, especially heavy wall thicknesses, can be made without danger of cracking. Dense weld deposits are completely machinable.

### Procedure:

Clean weld area. Vee out cracks with EWAC GougeTec after drilling holes at the ends of the cracks. Preheat is not required in most cases except for critical parts to 250°C. Direct arc on deposited weld metal. Lightly peen to relieve stress. Chip slag between passes. Use skip welding sequence in complicated assemblies. Cover casting and allow to cool slowly.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	110-120	85-100
4.00	130-145	110-120

**Tensiles Strength:** 400 MPa (57,000 psi)

**Hardness:** 80-90 HRb (3 layer)