

An Excellent Electrode for Repair of Casting Defects

Typical Applications :

Foundry defects, machine build up.

Outstanding Features :

- Excellent operating characteristics
- Dense deposits with good bonding
- Optimum machinability
- Stronger than conventional nickelbased cast iron welding alloys

Welding Procedure:

Clean weld area. Drill holes at ends of cracks and Vee out using EWAC GOUGETRO. Preheating is normally not required but may be employed upto 150°C for better machinability. Using minimum current and maintaining short arc gap, deposit stringer beads 25 to 75 mm long at a time. Back-whip craters. Peen each bead after deposition. Remove slag between passes.

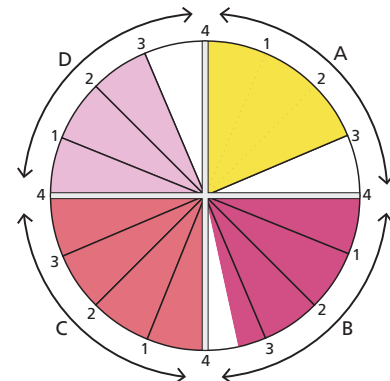
Recommendations :

Weld repair of foundry defects such as blow holes, shrinkage, cavities, missing sections etc, where a sound machinable deposit is essential. Also for rectification of machining errors and for building up worn out areas of cast iron parts.

Tensile Strength : 42 kg/mm² (60,000 psi)



Slurry Pump Repair



- A - Weldability 3
- B - Crack resistance 3½
- C - Bonding 3
- D - Machinability 3

Recommended Amperage:

Size (mm)	Amperage
4.00	85 - 110
3.15	60 - 85
2.5	50 - 60

