ARCTEC® 125 CAST IRON

a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® 125 CAST IRON is a nickel-iron type electrode for welding of cast iron. This electrode produces sound welds suitable for joining cast iron to steel. Despite high strength the deposit and transition zones are still machinable.

APPLICATIONS:

ARCTEC® 125 CAST IRON is used for repair or build up of cast iron and nodular iron and for joining these alloys to steel and other ferrous alloys. Frequently used in combination with other cast iron products in the Arctec line of cast iron welding alloys.

WELDING PROCEDURE:

Remove oil, grease, rust and other contaminants from base material prior to welding. Prepare joint as required. Remove slag and peen between passes. When preheat is used interpass and preheat temperatures must be maintained throughout welding. Upon completion of the weld cooling rates must be controlled. ARCTEC® 88 is recommended for use in joint preparation on cast iron components.

MECHANICAL PROPERTIES:

Hardness	Tensile Strength
200 HB (approx.)	65,000psi(448MPa)

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse or AC

Recommended Amperage:

Diameter	2.50mm 3/32"	3.25mm 1/8"	4.00mm 5/32"	5.00mm 3/16"
Amperage	40-95	70-125	110-160	125-190

Subject to change without notice