



a quality welding alloy

ARCtec® I39 CAST IRON

GENERAL CHARACTERISTICS:

ARCtec® I39 CAST IRON is a high nickel electrode specially coated to produce soft, machinable welds on cast iron without preheat. The special coating provides a smooth, soft arc, easy manipulation in all positions and a good bond with the parent metal. The deposit is dense and highly crack resistant and has a light slag cover that is easily removed. Transition zone is machinable and can be filed.

APPLICATIONS:

ARCtec® I39 CAST IRON is recommended for repair or build up of broken and worn castings such as machine bases, sprockets, levers, cast iron motor housings, frames, heavy cast iron components and other applications where bonding quality and machinability is a must.

WELDING PROCEDURE:

Remove oil, grease, rust and other contaminants from base material prior to welding. Prepare joint as required. Deposit short stringer beads of 1 to 1 1/2" (25 to 40mm) using a medium to long arc. Remove slag between passes and peen deposit to relieve weld bead stress. When preheat is used, interpass and preheat temperatures must be maintained throughout welding. Upon completion of the weld cooling rates must be controlled to assure sound weldments. ARCtec® 88 is recommended for use in joint preparation on cast iron components.

MECHANICAL PROPERTIES:

Hardness
170 HB (approx.)

Tensile Strength
50,000psi (345MPa)

OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Straight or AC

Recommended Amperage:

Diameter	2.50mm 3/32"	9.25mm 1/8"	4.00mm 5/32"	5.00mm 3/16"
Amperage	60-70	80-110	120-140	140-180

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