

ARCTEC® I CAST IRON



GENERAL CHARACTERISTICS:

ARCTEC® I CAST IRON is an economical all position electrode particularly suitable for repair of oxidized, oily, scaly, corroded and chemically affected cast iron components that do not require machining after welding. The deposit has good color match with cast iron and very little slag that does not require removal between passes. The deposit is machinable by grinding only.

APPLICATIONS:

ARCTEC® I CAST IRON is excellent for welding cast iron or cast iron components that are saturated with oil, grease, chemicals and other contaminants. Frequently used in foundry applications and for build up of worn section's subject to abrasion. Used as a first pass on aged or heat affected cast iron in combination with other cast iron products in the Arctec line of machinable cast iron welding alloys.

WELDING PROCEDURE:

Remove oil, grease and rust from base material prior to welding. Prepare joint as required. Do not preheat and do not allow the part to become overheated when welding. Interpass temperature and 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
350 HB (approx.)

Tensile Strength
60,000psi(413MPa)

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"
Amperage	50-90	75-110	100-150

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