

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

CALGARY FAX:(403)-250-7682	EDMONTON: (780)-484-4896	VANCOUVER: (604)-596-2940	WINNIPEG: (204)-663-7955
PHONE:(403)-250-9355	(780)-484-3304	(604)-596-6207	(204)-663-9182

The seller makes no warranties, express or implied, including, but not limited to, the implied warranties of merchantability and fitness for a particular purpose, except as expressly stated in seller's contract, delivery slip or invoice form. Technical data and suggested application are provided to assist you in making your own evaluations and decisions and should not be interpreted as expressed or implied warranties. Mechanical properties are typical or average values obtained by testing and comparing many heats of the same alloys. Minimum and maximum values are noted accordingly and are not intended for specific purposes.