

ARCTEC[®] 4 CAST IRON



GENERAL CHARACTERISTICS:

ARCTEC[®] 4 CAST IRON is a general purpose bare welding alloy for oxyacetylene (OAW) welding of cast iron. Weld deposit is machinable. Used with ARCTEC[®] Cast Iron Flux.

APPLICATIONS:

ARCTEC[®] 4 CAST IRON is recommended for repair and maintenance welding of castings such as machine bases, gear housings, manifolds, cylinder heads and engine blocks. Recommended for filling surface defects, restoration of missing or worn sections and other applications where color match with the base metal is critical.

WELDING PROCEDURE:

Remove, grease, rust and dirt by chiseling or grinding. Bevel heavy sections to a 75° included angle. Preheat to 840°F (430°C) before welding. Melt off a small amount of the rod using a slightly carburizing flame and continue heating the deposit until it is fused to the base metal. Repeat this procedure until the weld is complete. Use sufficient flux to ensure good cleaning action. Cool part slowly to prevent cracking.

MECHANICAL PROPERTIES:

Hardness	Tensile Strength
200 HB (approx.)	40,000psi(275MPa)

OPERATING PARAMETERS:

WELDING PROCESS: OFW (Oxyfuel Welding)

WORKING TEMPERATURE: 1,600°F (870°C)

AVAILABLE DIAMETER: 6.00M (1/4")

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