

# ARCTEC® SUPERCAST® 8000



## GENERAL CHARACTERISTICS:

ARCTEC® SUPERCAST® 8000 is a high quality versatile electrode for welding cast iron and alloyed cast iron. The unique core wire makes this electrode ideally suited for build up and cladding applications. This electrode provides excellent weldability in all positions on both direct and alternating currents. Deposits are sound, highly crack resistant and free from slag entrapment and porosity. Weld deposit is fully machineable.

## APPLICATIONS:

ARCTEC® SUPERCAST® 8000 is particularly suited for build up and cladding of cast steel, malleable and ductile castings. Used for repair and build up of gear teeth, sprockets, pump housings machine bases and engine blocks. Also suitable for joining cast iron to steel. The highest crack resistance is obtained when using alternating current.

## WELDING PROCEDURE:

Remove oil, grease and rust from base material prior to welding. When good welding practices are observed solid crack free repair and joining welds can consistently be made using ARCTEC® SUPERCAST® 8000 electrodes. Preheat is recommended on complex parts where multi-axial stresses are present. Preheat temperatures should not exceed 300°F. Interpass temperature and cooling rates should also be controlled to assure sound weldments. ARCTEC® 88 is recommended for use in joint preparation on cast iron components.

## MECHANICAL PROPERTIES:

Hardness	Tensile Strength
180 HB (approx.)	61,000psi(422MPa)

## OPERATING PARAMETERS:

WELDING PROCESS: SMAW

POLARITY: DC Reverse, Straight or AC

### Recommended Amperage:

Diameter	2.50mm 3/32"	3.25mm 1/8"	4.00mm 5/32"
Amperage	50-80	70-100	100-130

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