

# ARCTEC® SUPERCAST® 90



## GENERAL CHARACTERISTICS:

ARCTEC® SUPERCAST® 90 is a newly developed electrode for welding gray, malleable and nodular cast iron. Utilizing a specialized Bimetal core wire composition provides superior resistance to flux coating overheating and decomposition allowing for maximum deposition efficiency and excellent welding characteristics in all positions during the welding process. The flux coating is specially designed to provide a smooth, stable arc on both direct and alternating current. This electrode produces sound, crack resistant welds that are free from slag entrapment and porosity with exceptional bonding characteristics and machinability.

## APPLICATIONS:

ARCTEC® SUPERCAST® 90 is primarily intended for the deposition of sound, porosity and crack free welds on cast iron housings, sprockets, machinery housings and mounting bases, levers and heavy cast iron equipment. The weld deposit is smooth and spatter free with little convexity, allowing for easy tie in between stringer beads.

## WELDING PROCEDURE:

By observing good welding practices, solid crack free repair and joining welds can be made on gray, malleable and nodular cast iron by using ARCTEC® SUPERCAST® 90. Preheating is contingent upon the type and design of material being welded. Interpass temperature and cooling rates should also be controlled to assure sound weldments. Remove oil, grease and rust from base material prior to welding.

## MECHANICAL PROPERTIES:

Hardness	Tensile Strength
180 HB (approx.)	58,000psi(399 MPa)

## 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	75-100	90-120	120-150

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