



a quality welding alloy

## ARCtec® 2 CAST IRON

### GENERAL CHARACTERISTICS:

ARCtec® 2 CAST IRON is an economical all position electrode designed for cold welding of gray cast iron, malleable cast iron and spheroidal graphite castings. The mechanical property of this electrode makes it especially suitable for joining cast iron to steel. Despite high strength the deposit and transition zones are still machinable.

### APPLICATIONS:

ARCtec® 2 CAST IRON is a high strength electrode for repair or build up of oily or worn castings, valve housings, heavy cast iron equipment, foundry filling defects, malleable cast iron components and joining of ductile iron and these alloys to steel. Frequently used in combination with other cast iron products in the Arctec line of cast iron welding alloys.

### WELDING PROCEDURE:

Remove oil, grease, rust and other contaminants from base material prior to welding. Prepare joint as required. Deposit short stringer beads of 1 to 1 1/2" (25 to 40mm) using a short to medium arc. Remove slag and peen between passes. When preheat is used interpass and preheat temperatures must be maintained throughout welding. Upon completion of the weld cooling rates must be controlled. ARCtec® 88 is recommended for use in joint preparation on cast iron components.

### MECHANICAL PROPERTIES:

Hardness  
190 HB (approx.)

Tensile Strength  
66,000psi(455MPa)

### 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"	5.00mm 3/16"
Amperage	50-70	70-90	100-130	140-160

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