

*Perfect Pass*

**Welding Products**

**Distributed by Agri Tool & Supply**

**KOOL KAST  
2089**

**Data Sheet**

***Special copper/nickel bi-metal core wire revolutionizes  
cast iron electrodes.***

**PROPERTIES UNIQUE ONLY TO COOL CAST:**

- Special thermally conductive core wire is visually unique while totally eliminating overheating.
- Proprietary copper/nickel deposit chemistry offers the ultimate combination of machinability with outstanding ductility.

**DESCRIPTION:**

All position AC/DC coated electrode, depositing high nickel weld metal designed to produce soft machinable deposits on all grades of cast iron, particularly surfaces contaminated with oil, grease, dirt, oxides, etc.

**APPLICATIONS:**

- Joining cast irons to steels.
- Repairing dirty, rusty, oil-soaked castings.
- High stress joints.
- Safely repairs castings of unknown analysis.
- Repairs requiring greatest ease of machining.
- Circumferential welds.

**HOW TO USE:**

**Equipment:** Any constant current AC transformer or DC generator/rectifier designed for "stick" welding regardless of available open circuit voltage.

**Procedure:** Clean surface if possible, otherwise weld through contamination. Adjust amperage within recommended range and deposit electrode maintaining short to medium arc length. Tilt electrode 30 degrees in direction of travel. Use stringer bead or moderate weave technique and back-whip all craters. On DC use reverse polarity.

**TYPICAL PROPERTIES:** Tensile strength - In excess of 76,000 psi



**ELECTRODE SIZE**

3/32"  
1/8"  
5/32"

**RECOMMENDED AMPERAGE RANGE**

60 - 90 amps  
85 - 120 amps  
110 - 150 amps

**AGRI-TOOL & SUPPLY • P O BOX 612 • Greenacres WA 99016  
(509) 928-1872 • (800) 321-5460 • FAX (509) 926-6618**