



Welding Products

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NA 111

Data Sheet

PREMIUM NICKEL ELECTRODE FOR WELDING CAST IRON - MAXIMUM MACHINABILITY AC OR DC STRAIGHT (ELECTRODE-)

GENERAL CHARACTERISTICS:

Specially formulated coating gives a pulsed arc for low temperature welding of cast irons. When properly applied the arc will penetrate surface skin and contaminants to produce a porosity free weld. The heat affected zone is not hardened and stress cracks are almost always avoided.

APPLICATIONS:

Low temperature welding of cast iron in all positions. Repairs breaks and cracks in engine blocks, gear housing, and machine bases. Ideal for filling holes and building up worn or missing sections which must be machined to final dimension after welding. Also for joining cast iron to steel, iron, stainless steel, copper, Monel, etc.

TECHNICAL DATA:

Tensile Strength up to 50,000 psi (345 N/mm²)
 Hardness (HB) approx. 160
 Color Match similar to cast iron
 Current AC or DC straight polarity (electrode-)

Amperage	30-70	55-110	75-135	100-175
(in)	3/32"	1/8"	5/32"	3/16"
(mm)	2.5	3.25	4.0	5.0

PROCEDURE:

Clean weld area if possible. Bevel joint to form a "U" Groove. A hole should be drilled at each end of all cracks to prevent spreading during welding. Select lowest possible amperage. Maintain a medium long arc with electrode tilted slightly in the direction of travel. Short stringer beads or narrow weave beads should be used to prevent excessive heat build-up. When breaking the arc always fill the crater and drag rod back over the weld deposit. Peening while still hot will help reduce stresses. When restriking the arc start on previously deposited weld metal, not on the base material. Allow part to cool slowly.