



Perfect Pass is a line of quality-first maintenance & repair alloys.

WIRES • POWDERS • STICK ELECTRODES

KOOL KAST #2089 DATA SHEET

SPECIAL COPPER/NICKEL BI-METAL CORE WIRE REVOLUTIONIZES CAST IRON ELECTRODES

GENERAL CHARACTERISTICS:

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

MECHANICAL PROPERTIES:

- | | | | |
|-------------------------|----------------------|--------|---------|
| • Tensile Strength | Excess of 76,000 psi | | |
| • Current and Polarity: | DC Reverse polarity | | |
| • Diameter's: | 3/32" | 1/8" | 5/32" |
| • Amperage Range: | 60-90 | 85-120 | 110-150 |

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.



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