



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

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# NA115

## DATA SHEET

### PREMIUM HIGH NICKEL MIG WIRE FOR WELDING CAST IRON

#### GENERAL CHARACTERISTICS:

Specially formulated high nickel wire for MIG welding cast iron requiring smooth, splatter free machinable deposits. Perfect Pass NA115 provides dense deposits with high ductility on cast irons that are not severely contaminated.

#### APPLICATIONS:

Use Perfect Pass NA115 where minimum heat input and dilution are required, repairing, or building up engine blocks, gear housings, and machine bases. Excellent for filling holes or building up missing sections, underlayment for hard facing, and may also be used for joining cast iron to steel, stainless steels, and other similar materials.

#### MECHANICAL PROPERTIES:

- |                     |   |
|---------------------|---|
| • Tensile Strength: | up to 50,000 psi (345 N/mm <sup>2</sup> ) |
| • Hardness (HB):    | approx. 160 HB                            |
| • Shielding Gas:    | 100% Argon or 75/25 AR/O <sub>2</sub>     |
| • Diameter:         | .035" .045"                               |
| • Volts:            | 16-20V 20-22V                             |
| • Amps:             | 125-160A 140-190A                         |
| • Current:          | DC Reverse (Electrode +)                  |

#### PROCEDURE:

Remove foreign materials. Preheat to 400°F using short arc procedures. Apply weld with stringer beads with slight side to side motion. Fill all craters and peen welds to relieve stress.



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REV. 9/2023