



Pump Casing

## A high Ni electrode for repairing thin sections of gray cast iron with excellent machinability

### Typical Applications:

Engine blocks, cast iron gears and pulleys, sliding tables for machine tools, cylinder heads.

### Outstanding Features:

- Superior crack resistivity.
- Welding of weldable grades of CI.
- "Cold arc" coating offers minimum base metal penetration and dilution.
- Best for thin sections.
- Superior for out-of-position welding.
- Ideal for cladding.

### Recommendation:

Welding of cast iron part with minimum heat input. Superior for thin gray cast iron. Excellent for building up missing sections, cladding, filling holes, repairing broken and cracked Cast Iron.

### Procedure:

Clean weld area to remove scale, grease and dirt. Drill holes at starting and end of cracks. Remove cracks with Eutec-ChamferTrode electrode. For restraint joint preheat part to around 200°C. Use a short to medium arc at minimum amperage. Use stringer bead, follow skip / staggered technique. Peen weld deposit to relieve stresses. Skip weld to avoid excessive local heat. Remove slag between passes. Use buttering layer of EutecTrode 27 on contaminated surfaces. Allow to cool slowly.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	60 - 75	35 - 50
3.15	90 - 110	55 - 80
4.00	110 - 130	80 - 100

**Tensile Strength:** 35 Kg/mm<sup>2</sup>  
(50, 000 psi)