



Gear Box Housing

Electrode for welding of heavy sections and crack sensitive cast iron applications.

Typical Applications:

Machine bases, pumps and differential housings, cast iron dies

Outstanding Features:

- Excellent weldability.
- Ideal for heavy cast iron sections.
- Machinable deposits.
- For joints subjected to hydrostatic pressure.

Recommendation:

For crack-sensitive applications such as castings involving hydrostatic pressure, joints under restraint, dissimilar thicknesses and the general welding of very heavy sections. Excellent for joining cast iron to steel. Circumferential pipe welds, especially heavy wall thicknesses, can be made without danger of cracking. Dense weld deposits are completely machinable.

Procedure:

Clean weld area. Vee out cracks with EWAC GOUGETRO after drilling holes at the ends of the cracks. Preheat is not required in most cases except for restraint joints preheat to 250°C. Direct arc on deposited weld metal. Lightly peen to relieve stress. Chip slag between passes. Use skip welding sequence in complicated assemblies. Cover casting and allow to cool slowly.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	110 - 120	85 - 100
4.00	130 - 145	110 - 120

Tensile Strength: 42 Kg/mm²
(58,500 psi)