

**Pump Casing**

Electrode with higher Ni content for repairing of thin sections of grey cast iron with superior 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 grey 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 EWAC GOUGETRO. 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 EWACTRO CI 54 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: 37 Kg/mm²
(52, 000 psi)