



**Motor Casing**

## **Specially designed electrode with strong arc force and cleaning action for contaminated cast iron applications.**

### **Typical Applications:**

Buttering layer on contaminated cast irons, cast iron defects, cast iron furnace equipment sealing oil-soaked cast iron parts.

### **Outstanding Features:**

- Nickel-free deposits.
- Spray type of metal transfer.
- High tolerance to impurities.
- Excellent colour match to grey cast iron.

### **Recommendation:**

Non-conductive coating prevents side arcing greatly aids welding in tight corners and deep holes. Used as a single layer buttering on all cast irons. Exceptional performance on contaminated surfaces. Deposit exhibit colour match on cast irons.

### **Procedure:**

Clean weld area, drill holes at the starting and end of crack on Cast Irons. Use EWAC GOUGETRO for preparing U-groove. Deposits offer spray type of metal transfer. The welding alloy should be deposited on base metal with the electrode tilted slightly in the direction of travel. Do not weave. Use short beads not exceeding 30 mm, back whip crater. Remove slag by chipping and brushing. Not recommended for joining only buttering.

### **Recommended Amperages:**

<b>Size (mm)</b>	<b>I - Range</b>	<b>II - Range</b>
3.15	105 - 125	70 - 95
4.00	130 - 150	95 - 120