



Cylinder Head

Electrode with unique core wire design gives good weldability, high tensile strength, ductility and machnability meant for wide range of cast iron and cast iron to steel applications.

Typical Applications:

Machine tool bases, valve body, pumps, gear boxes, gear teeth, couplings, piping, transmission housing etc.

Outstanding Features:

- Dense deposits with excellent machinability
- High tensile strength and high ductility ensure maximum safety margin.
- Wide range of base metal (CI) compatibility.
- Special core wire and flux coating permits consistent, porosity free welding.
- High arc force purges out impurities.

Recommendation:

Joining of cast iron and cast iron to steel of similar / dissimilar thicknesses. Repair welding of high strength, heavy duty ductile irons involving massive section and for joints under restraints.

Procedure:

Clean weld area. Drill holes on the starting and end of cracks. Remove damaged metal using EWAC GOUGETRO electrode. In most cases part should be welded cold (maximum inter-pass temp 60°C). For complicated parts preheat to at least 300°C. Using short arc at lowest amperage, deposit stringer bead with skip welding. Chip slag with wire brush and peen each deposit.

Recommended Amperages:

| Size (mm) | I - Range | II - Range |
|-----------|-----------|------------|
| 2.50 | 90 - 100 | 70 - 80 |
| 3.15 | 110 - 120 | 90 - 100 |
| 4.00 | 145 - 160 | 120 - 135 |

Tensile Strength: 53 Kg/mm²
(75,000 psi)