



HI-ALLOY 64

NON-MACHINABLE CAST IRON ELECTRODE

DESCRIPTION: Hi-Alloy 64 is an all position electrode which can be used to repair cracks or breaks in cast iron where machining is not required after welding. The weld deposit will have a good color match to cast iron and will rust similarly when exposed to the elements.

TYPICAL APPLICATIONS: Hi-Alloy 64 may be used for welding of castings that are saturated with chemicals, oil, grease, or other contaminants which make welding seem impossible. It may be used for joining problem castings to steel, to salvage furnace grates, and to make butter passes on parts to prepare the surface for welding with a machinable electrode such as Hi-Alloy 400 or Hi-Alloy 460.

PROCEDURES: Clean the area to be welded as much as possible, grind a vee or use Hi-Alloy Metal Mover to gouge or bevel the area to be welded, preheat of 400° - 500° F should be used on heavier sections, (if repairing a crack, drill a small hole at each end to prevent spreading and use no preheat), use the lowest possible amperage to maintain a short stable arc, skip weld with beads of ½" to 1½" dependent on the length of repair and thickness of the part. Be careful not to overheat the casting, and provide for slow cooling after welding.

AVAILABLE SIZES: 3/32 1/8

AMPERAGE RANGES: 50 - 80 75 - 110

POLARITY: AC or DC Reverse

TENSILE STRENGTH: Up to 60,000 psi