



HI-ALLOY CAST IRON PLUS

TRI - METALLIC ALLOY FOR CAST IRON

DESCRIPTION: The unique Tri-Metallic design of this electrode creates the ultimate combination of characteristics desired for cast iron welding. This electrode will not overheat thus eliminating flux breakdown and preventing weld deposit defects. High tensile strength and superior elongation allow for repair of nodular, ductile, malleable, and gray cast irons. Flexibility of welding polarity provides for control of weld metal dilution and depth of the heat affected zone, resulting in exceptional machinability.

TYPICAL APPLICATIONS: Repair of cast iron dies, engine blocks, pump housings, gears, cylinder heads, heavy equipment parts, and joining cast and ductile irons.

PROCEDURES: Remove cracked, contaminated, or worn metal with Hi-Alloy Metal Mover or by grinding. Preheat heavy sections to 500° - 600° F. Weld with the lowest amperage which provides a short stable arc and good wetting. On thin sections and when cold welding, weld beads should not exceed 1 to 1½" to minimize heat input. Peen all welds immediately with the ball end of a ball peen hammer to distribute stresses. Allow finished weld to cool slowly in still air.

AVAILABLE SIZES: 3/32 1/8 5/32

AMPERAGE RANGES: 50 - 75 70 - 100 100 - 300

POLARITY: AC, DC Reverse, or DC Straight

TENSILE STRENGTH: Up to 77,000 psi

HARDNESS: Rockwell B 84 - 88