

# Inweld CI 290

General Purpose, Oxy-Acetylene Torch Welding Alloy for Cast Iron

## Chemical Composition of Inweld CI 290

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
--	--	--	--	--	--	--	--	--	--	--

Chemical composition not available.

## Description and Applications

Inweld CI 290 was developed to repair a wide variety of cast irons, including joining applications that require excellent color match and compatible properties to the base metal. CI 290 is especially good for filling porous areas, build-ups, and joining many grades of cast iron. All deposits are dense and machine-able. Inweld CI 290 is ideal for use on cast housings, machine frames, and building up worn or missing areas. Inweld CI 290 is perfect for salvaging castings scrapped for machining or casting flaws. To use, clean and bevel joint. Heat uniformly and keep torch in motion. Apply Inweld CI 290 Flux on rod and work piece. Continue heating to liquefy. Apply Inweld CI 290 one drop at a time. Make certain each drop wets out. Do not overheat base metal, and cool slowly.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Hardness:	190 HB
Tensile Strength:	40,000 psi
Yield Strength:	
Elongation:	
Working Temperature:	1600F (871C)

**INWELDCORPORATION.COM**

**Pennsylvania**  
3962 Portland Street  
Coplay, PA 18037

**North Carolina**  
1029 S. Marietta St.  
Gastonia, NC 28054

**Texas**  
9300 Lawndale St.  
Houston, TX 77012

**California**  
6201 Coliseum Way, Unit A  
Oakland, CA 94621