

Inweld CI 717

Economical Electrode for Difficult to Weld Cast Iron

Chemical Composition of Inweld CI 717

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
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Chemical composition not available.

Description and Applications

Inweld CI 717 produces high strength, non-machine-able deposits that have a very close color match to cast iron. It can be operated efficiently in all positions and is typically used on heavy sections such as machine bases. Welding of castings that are impregnated with oil, grease, paint, or other contaminants that make repairs with nickel electrodes impossible. It is often used to repair castings that have vbeen burned, such as furnace grates and other problem cast irons. Inweld CI 717 can be used as a buttering pass before using machine-able cast iron electrodes or as a wear resistant layer for build-up of areas exposed to abrasion. To use, grind or gouge out crack using Inweld MX 222/414. Clean weld zone in accordance with standard welding practice. Do not preheat. Use lowest effective amperage while maintaining a short arc length. Deposit short beads and skip weld to reduce heat input. Allow casting to cool slowly.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	60,000 psi
Yield Strength:	
Elongation:	33%

Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"	35-80	
1/8"	75-110	
5/32"	100-150	
3/16"	110-150	

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