

Inweld CX 888

Premium Alloyed Electrode for Welding All Cast Iron – High Strength AC or DC Straight (Electrode -)

Chemical Composition of Inweld CX 888

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

Description and Applications

A true universal high strength casts iron electrode specifically developed for maintenance and repair welding of all commonly known types of cast iron. The special core wire features a high current capacity, and the flux coating is designed to transfer impurities from the base metal into the slag. Due to its relatively high nickel content is easily machined. Excellent for out of position welding. For fabrication and difficult repair of all gray and alloyed cast irons. Recommended for welding cylinder heads, machine bases, gear housings, cams, levers, repairing teeth of cast gears, and building up or replacing missing sections. Commonly used to weld ductile iron, "Ni-Resist" and "Meehanite" to themselves or to steel. Also suitable for joining nickel alloys to gray cast iron, malleable cast iron, and cast steel. To use, clean weld area if possible. Remove surface skin and all sharp edges. Bevel joining to form a "U" groove. A bead hole must be welded at right angles to each end of all cracks to prevent spreading during welding. Use low amperage and maintain a short arc. Short stringer beads or narrow weave beads should be used to prevent excessive heat build-up. When breaking the arc always fill the crater and drag rod back over the weld deposit. Peening while still hot will help reduce stresses. When re-striking the arc, start on previously deposited weld metal, not on the base material. Allow part to cool slowly.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Brinell Hardness:	200
Tensile Strength:	80,000 psi
Yield Strength:	
Elongation:	20%

Recommended Parameters

SMAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
3/32"	35-80	
1/8"	65-120	
5/32"	75-140	
3/16"	100-170	

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