

## Cast-Weld™ HPM Ultimate Machinable Cast Iron Electrode

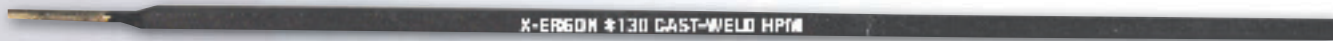
Cast-Weld HPM's special coating prevents the electrode from overheating, like conventional cast iron electrodes.

- Machinable deposits with no hard spots.
- All-position — even in the downhill position
- Perfect for dissimilar cast iron combinations — will join all weldable grades of cast iron, cast to steel and cast to stainless
- Nonconductive flux — permits welding into holes or cracks without danger of side arcing
- Versatile — welds all weldable grades of cast iron: gray, malleable, alloyed, ductile, mechanite, nodular, and Ni-Resist



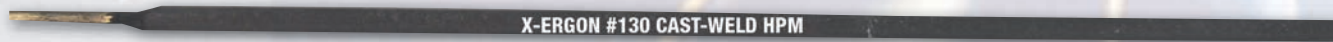
### SPECIFICATIONS

Tensile strength.....	60,000 psi/414 MPa
Yield strength.....	45,000 psi/310 MPa
Hardness.....	up to 80 Rb
Machinability.....	Excellent
Color match.....	Excellent
Current.....	DCEP (DC+) or AC



### PROCEDURE

Preclean the weld area to remove surface contaminants such as grease, oil, rust, paint, etc. Bevel sections over 1/8" thick to a 75°-90° "U" shape. To prevent contamination of the weld area, the use of X-Ergon Arc-Prep™ to chamfer or bevel the area to be joined is preferred over grinding with an aluminum oxide wheel. On smaller repairs, Partsmaster Cryo-Burrs™ should be used. When welding a crack, it is advisable to drill a small hole 1/4" past each end of the crack to prevent it from migrating during the welding operation. Use the lowest practical amperage on AC or DCEP. Use a gap, drag or narrow weave technique and "butter" the sides of multipass welds before completing fill passes. When welding mismatched parts, undercut the entire area to be machined and then reweld. This prevents having to machine across the heat-affected cast iron, which contains carbides, unless the part is post-weld heat-treated. When joining long cracks, use the "back step" method. Always finish off a pass by bringing the electrode back into the weld puddle before breaking the arc. Peening while hot helps relieve stress in the weld. Cool slowly in still air.



### APPLICATIONS

- |                      |                       |                      |
|----------------------|-----------------------|----------------------|
| • Cams               | • Piping              | • Buildups           |
| • Cylinder heads     | • Machinable overlays | • Pump housings      |
| • Valve bodies       | • Flywheels           | • Motor housings     |
| • Machine tool parts | • Valve seats         | • Gear cases         |
| • Gear boxes         | • Gear teeth          | • Transmission cases |
| • Axle housings      | • Crankshafts         | • Sprockets          |

Code #	Diameter	Amperage
130-3-0000	5/32"	90-140
130-4-0000	1/8"	65-110
130-5-0000	3/32"	35-80



Available in select sizes only

For kits see page 6