

Cast Weld™ T Superior Machinable Cast Iron TIG Alloy

- Acceptable for use on food handling equipment
- Joins cast iron to dissimilar metals
- Excellent flow characteristics for better welds
- Excellent machinability
- Can be used on all types of weldable cast irons



SPECIFICATIONS

Tensile strength.....	60,000 psi/413 MPa
Hardness.....	80 Rb
Machinability.....	Excellent
Color match.....	Good
Current.....	DCEN
Gas.....	100% Argon

PROCEDURES

Clean the base metal of all surface contaminants and oxides. Degrease thoroughly with Metal Groom™. Preheating is required on larger weldments. Use DCSP with argon shielding gas and maintain a wide arc gap. Use a circular technique or a wide weave. Allow molten alloy to wet on the cast iron surface. Peening is recommended. Keep shielding gas in place during cooling. The use of X-Ergon Rare Earth or 2% Thoriated electrodes is recommended. Cup size and gas flow are determined by electrode diameter, current and welding conditions. If metal is not free of contaminants, X-Ergon Cast-Weld coated stick electrode is recommended.

APPLICATIONS

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|-------------------------|--------------------|----------|
| • Valve bodies | • Machining errors | • Shafts |
| • Cams and crank shafts | • Worn surfaces | • Rolls |
| • Housings | • End bells | |
| • Blocks | • Cylinder heads | |
| • Water jackets | • Pulleys | |

Code #	Diameter	Length
200-4-130T	1/8"	36"
200-5-130T	3/32"	36"
200-7-130T	1/16"	36"

Also available in:

