UNITED ALLOYS
RESEARCH & DEVELOPMENT INC.

125 BLACKSTONE AVE.

JAMESTOWN, NY
1-800-356-WELD

PROBLEM SOLVER SUPERCAST

SUPERCAST

SPECIALLY DESIGNED FOR DIRTY CAST IRON. THE PROBLEM SOLVER TO USE WHEN ALL OTHERS FAIL

AC/DC REVERSE POLARITY (ELECTRODE +)

GENERAL CHARACTERISTICS:

Unique flux coating on alloyed Bi-metal core wire produces dense, strong, crack-resistant welds on all types of cast iron. Especially good for contaminated, old, oil-soaked, dirty base metal. Also recommended for joining cast iron to steel. Use on gray, ductile, Meehanite, and nodular cast iron. Deposits are machinable.

APPLICATIONS:

Use on sewer pipe, machine bases, transmission or gear housings, sprockets, repair of or build-up on gears, and any repair of cast iron to steel.

TECHNICAL DATA:

Tensile Strength..... ……..up to 72,000 psi
Hardness ..... Brinell 210
Current ..... AC or DC reverse polarity

Amperage	40-70	70-120	90-130	110-170
(in)	3/32”	1/8”	5/32”	3/16”
(mm)	2.5	3.25	4.0	5.0

PROCEDURE:

On heavy sections, remove worn, cracked metal, and bevel joint using Chamfertrode or a grinding wheel. When repairing cracks, drill “stop” hole at either end to prevent spreading while welding. On very heavy sections, preheat to approximately 350°F. Use short stringer beads for root pass and peen lightly after removing slag. Use a short to medium arc and the lowest amperage possible to minimize base metal over-heating. When breaking arc, always back whip into weld crater. Weaving two times rod diameter is acceptable for cover beads on multi-pass work. Weld joints should be allowed to slow cool for maximum strength and machinability.

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