

# CASTEX 1

## HIGH STRENGTH, ECONOMICAL NICKEL FREE ELECTRODE FOR WELDING CAST IRON

**AC OR DC REVERSE (ELECTRODE+)**

### GENERAL CHARACTERISTICS:

An inexpensive electrode that can be used in all positions to repair castings that do not require machining after welding. Deposits have close color match to cast iron and if exposed to the atmosphere will rust like the original casting.

### APPLICATIONS:

Welding of castings that are saturated with oil, grease, chemicals, and other contaminants that make welding with other rods almost impossible. Often used to repair burned furnace grates and to join problem cast irons to steel. This electrode is also used as the first pass or as a covering for the cast iron; final passes are put in with one of the machinable electrodes. Commonly used to weld cracked machine bases, housings, and for build-up of worn areas subjected to abrasion.

### TECHNICAL DATA:

Tensile Strength..... up to 65,000 psi (414 N/mm<sup>2</sup>)  
Hardness (HB) ..... approx. 350  
Color Match ..... good  
Current ..... AC or DC reverse polarity (electrode+)  
Amperage                      75-110 100-150  
(in)..... 1/8"                  5/32  
(mm)..... 3.25                4.0

### PROCEDURE:

Chip or vee out crack. Drill hole at each end of break to prevent spreading while welding. Do not preheat. Use lowest amperage possible, maintain a medium short arc. Short 1½" deposits are recommended. Skip weld on long cracks. Do not allow part to become overheated. Allow to cool slowly.

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