

ULTRACAST

PREMIUM DUCTILE IRON ELECTRODE FOR MULTI-LAYER WELDS WHERE HIGH STRENGTH AND HIGH DUCTILITY IS ESSENTIAL

RUN ON; DCEP OR AC

GENERAL CHARACTERISTICS:

Graphite coated electrode for welding ductile iron when ductile deposits are required. Special bi-metal core wire prevents overheating.

APPLICATIONS:

Use on all weldable grades of ductile iron when multi-layer deposits requiring high strength, good ductility and machinability are a must.

TECHNICAL DATA:

Tensile Strength.....67,763 psi
Yield Strength 58,000 psi
Elongation % UP TO 14%
Hardness HB 200

Current AC or DCEP

Amperage 70-100	90-150	110-180
(in) 3/32"	1/8"	5/32"
(mm) 2.5	3.25	4.0

Specification AWS A5.15

TYPICAL WELD METAL ANALYSIS

CARBON	MN	SI	NI	PHOS	CU	FE
1.4	2-6.8	0.57	42-50	0.10	0.12	BAL.

PROCEDURE:

Clean weld area as much as possible. On heavy sections, remove worn, cracked metal, and bevel joint using Chamfertrode or a grinding wheel. If the weld area is contaminated with oil or grease it may be removed by using a strong oxidizing oxy-acetylene flame to burn it off. On very heavy sections, preheat to approximately 450°F.

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**ALSO AVAILABEL IN MIG AND TIG

BI-METAL ULTRACAST