



SUPERCAST M

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

GENERAL CHARACTERISTICS

UNIQUE 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 AND USES

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 201
CURRENT TYPE PROTECTION....AC OR DC REVERSE POLARITY

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 450°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. INTER PASS TEMP. 500-650 DEGREES F.



AMP	90-160	120-180	220-270	300-360
IN	.035"	.045"	1/16"	3/32"
MM	0.9	1.2	1.6	2.4

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