

HA - 99

CAST IRON STICK-ELECTRODE FOR REPAIRS

CHARACTERISTICS:

- a distinct extruded electrode with a special flux developed for repairing grey cast and malleable cast iron;
- often used as a cushioning layer before using a ferro-nickel type electrode;
- very smooth flowing characteristics in all positions;
- multi-pass capabilities;
- excellent cushion layer for hardfacing alloys;
- deposit has excellent machinability characteristics.

MECHANICAL PROPERTIES:

- Tensile : 70,000 psi.
- Elongation : 35 to 45%

PROCEDURE:

- DC reversed polarity, 5/32" - 120 to 150 amps, 1/8" - 90 to 110 amps, 3/32" – 50 to 80 amps;
- remove all damaged material;
- gouge thick sections if necessary with HA-92 gouging rod;
- preheat to 250°F;
- using a stringer bead technique, allow each pass to cool before removing slag;
- in order to reduce local stress, peen each welded pass;
- avoid thermal shock;

TYPICAL APPLICATIONS:

- transmission boxes, machine bases, engine heads, reducers, cylinder chambers, and other miscellaneous cast parts.

OTHER:

- available in diameters of 5/32", 1/8" & 3/32";
- packaging: 10 lb. (4.5kg.) boxes.

