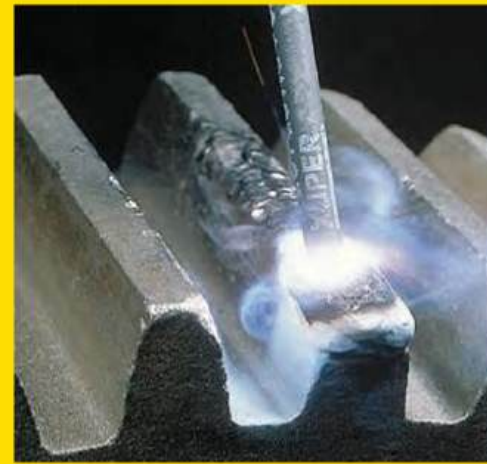


High Nickel Machinable weld deposits for Contaminated or Oil-Soaked Cast Irons

EC 230N



WELDING

- Recommended for sealing and joining unknown grades of cast iron
- Weld deposits are dense, and machinable
- Special formulation for welding cast iron that is old, oil-impregnated or with surface oxidation



DESCRIPTION:

EC 230 N is the ideal electrode when welding unknown grades of gray cast iron, particularly when the casting is seriously contaminated with oil, sulfur, etc. EC 230N is also useful for welding cast irons whose service conditions have oxidized the surface such as furnaces, molds and combustion chamber walls. This easily handled electrode puts down dense, porous free and machinable weld deposits.

TECHNICAL DATA:

Typical Tensile Strength: 250-300 N/Sqmm
Polarity: AC/ DCEP (+, preferred)

Diameter:	Amperage:
3/32" (2.4mm)	50-80
1/8" (3.2mm)	70 - 100
5/32" (4.0mm)	100 - 130

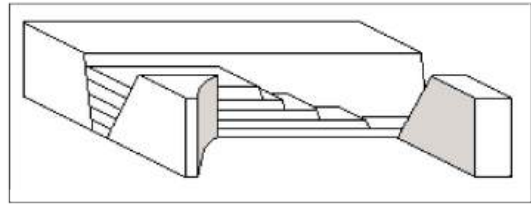
TYPICAL APPLICATIONS:

- Furnace Equipment
- Compressor Cases
- Gearboxes
- Engine Block Water jackets
- Oil Pumps
- Hydraulic Cylinders
- Pump-rotors

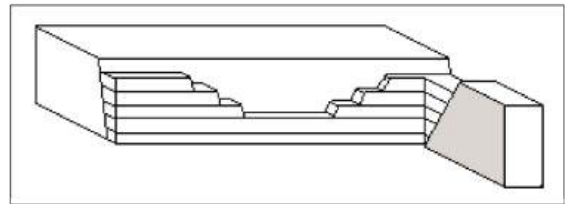
WELDING PARAMETERS:

Preparation: Prepare area to be welded by chamfering with either Eutectic ChamferTrode® or ExoTrode®. Cracks should be prepared with either a single-V or double-V depending on casting thickness and accessibility. Allow a 1/8" root opening for full-penetration welds. Preheat large castings to a minimum of 400°F (**Note: pre-heat temperature will vary with casting size, type and condition**).

Technique: Deposit short stringer beads no longer than 2". Moderately peen the 2nd and subsequent passes. Use either a cascade or block deposition sequence (see figures below) for large sectional thickness castings. Maintain pre-heat/interpass temperature until welding is complete.



Cascade Sequence: Weld metal is deposited in overlapping layers.



Block Sequence: Weld metal is deposited in intervening increments.

Post-Welding: Slow cool after welding using insulating material such as vermiculite or heat-retardant blankets.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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