

AMTEC 3 CAST IRON WIRE
MIG WIRE AND TIG WIRE

General Characteristics

Amtec 3 Cast Iron MIG and TIG is a solid bare wire whose properties are of a full nickel metallurgical structure. It is designed for use on ductile, malleable and grey cast iron in all positions where easily machined welds are required. The wire may be used with the TIG process or with the MIG process utilizing the spray, pulsed arc, or short-arc methods. DC current should be used in all applications with Straight Polarity for TIG applications while Reverse Polarity with Constant Voltage is required for MIG applications. Argon shielding gas should be used with TIG applications, and Argon/CO₂ (75/25) should be used for MIG applications. This product produces ductile welds, while maintaining high machinability.

Procedure

Remove contaminants from the welding zone. Pre-heat is normally not necessary, but may be helpful on large, heavy sections, or fully restrained joints. Use the following welding parameters for the MIG wire.

GAS	WIRE FEED	VOLTAGE	CURRENT	STICK OUT	TRAVEL SPEED
75/25	300	24	130	1/2	15
75/25	400	25	160	1/2	15
75/25	500	26	180	1/2	15
Argon*	500	28	220	1/2	15

* denotes Spray Transfer

Application

For the repair of cast iron to themselves and other materials, and for repairing worn or broken parts, and for salvaging defective castings where maximum ductility and machinability are required.

Tensile Strength	71,000 PSI
Yield Strength	49,000 PSI
Elongation	12%
Hardness (H.B.) Brinell	Approx. 160

Available in TIG wire sizes 1/16 and 3/32 x 36 or in MIG wire in .035 and .045 x 5 lb. or 25 lb. spools.

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