

AMTEC 1 CAST IRON AC/DC REVERSE ELECTRODE



General Characteristics

An economical alloy, particularly suited for repairing scaly and corroded castings where machinability is not a factor. An all position electrode, giving an outstanding bond with aged and/or corroded cast iron. The deposit has very little slag, which does not need to be removed between passes. Machinable by grinding only.

Tensile Strength	-	60,000 PSI
Elongation	-	20%
Hardness (HB) Brinell	-	Approx. 350

Diameter		Amps(approx.)
(Inch)	(MM)	
3/32	2.5	50-80
1/8	3.25	75-110
5/32	4.0	100-150

Procedure

Keep a short arc, only weld short beads (30-50 mm, 1.25-2 inches). It is recommended that you peen the weld deposit to relieve weld beadstress. Do not allow part to become overheated. Skip weld on long cracks. Allow part to cool slowly.

Application

For the welding of oxidized, scaly, corroded, and chemically affected cast iron. It is recommended for quality applications in foundries and in combination with the other electrodes in the Amtec line of cast iron. It is used as a butter pass on contaminated cast iron prior to build-up with other machinable cast iron electrodes.