



Maintenance and Repair Electrode for
Contaminated or Oil-Soaked Cast Irons

EutecTrode® 244



- Excellent tie-in and fluidity characteristics
- Excellent for low temperature welding of cast irons
- Unique chemistry for in-process weld cleaning and little to no spatter
- Ductile matrix imparts high crack resistance

EutecTrode® 244

EutecTrode 244 specially formulated coating gives a pulsed arc for low temperature welding of cast irons. When properly applied the arc will penetrate surface skin and contaminants to produce a porosity free weld. The heat affected zone is not hardened and stress cracks are almost always avoided.

TECHNICAL DATA

Typical Values	
Tensile Strength:	53,000 psi (365 MPa)
Yield Strength:	37,000 psi (255 MPa)
Hardness:	80 HB
Polarity:	AC/DCEN (-) or DCEP (+, preferred)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
Amp	30-70	55-110	75-135

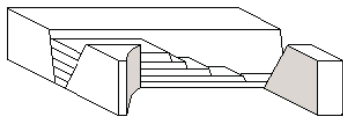
PROCEDURE FOR USE

PREPARATION

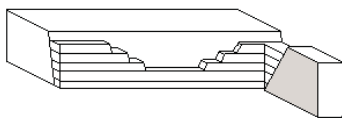
Prepare area to be welded by chamfering with either Eutectic ChamferTrode® or ExoTrode®. Cracks should be prepared with either a single-V or double-V depending on casting thickness and accessibility. Allow a 1/8" root opening for full-penetration welds. Preheat large castings to a minimum of 400°F (Note: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

WELDING 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 preheat/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.

TYPICAL APPLICATIONS

Low temperature welding of cast iron in all positions. Repairing breaks and cracks in engine blocks, gear housings and machine bases. Ideal for filling holes and building up of worn or missing sections which must be machined to final dimension after welding. Also for joining cast iron to steel, iron and stainless steel.

