



Premium Nickel-Iron Electrode
for Superior Cast Iron Welding

Xuper® 2233N



- All position, AC/DC electrode for joining, build-up and overlays
- Durable, crack-resistant welds with great machinability
- High quality core wire reduces overheating and flux breakdown, meaning less stub loss
- Good for nodular and ductile cast irons, sections under restraint and dissimilar joints of cast irons and plain steels

Xuper® 2233N

Xuper 2233N is a low-amperage, cored wire, flux-coated electrode for welding the widest range of cast irons as well as for welding cast iron to steel. Deposits are highly crack-resistant with superior machinability. Improved weldability and wash characteristics result in weld beads that are flat, even, and finely rippled. The advanced core wire prevents overheating at rated amperage reducing stub loss while maintaining weldability. The smooth stable arc has great strike and re-strike characteristics with minimal spatter and fuming.

TECHNICAL DATA

Typical Values

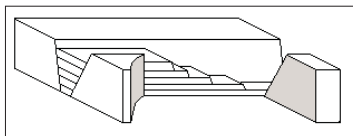
Tensile Strength:	72,000 psi (496 N/mm ²)
Yield Strength:	58,000 psi (400 N/mm ²)
Hardness:	87-90 HRB
Elongation:	15%
Current polarity:	AC or DCEP (electrode +)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	90-100	110-130	145-160

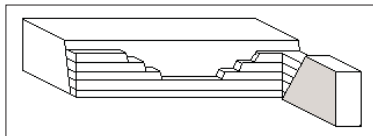
PROCEDURE FOR USE

PREPARATION: Clean joint and/or parts to be welding thoroughly. Terminate crack growth by drilling ¼" holes at the leading points. Preheat casting to 400°F, holding for 1 hour per inch of thickness. Prepare joint with Eutectic ChamferTrodé® or ExoTrodé®. Joints below 1" should be beveled to a V-profile; Over 1" can be beveled to either a single or double J-profile. Allow a root opening of 1/8" for full penetration welds.

TECHNIQUE: Deposit short runs no longer than 2-in. and moderately peen 2nd and subsequent passes. For long cracks in heavy castings use either a cascade and/or block deposition sequence.



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

Ideal solution for a variety of cast iron repairs under demanding conditions, joints under severe restraint, dissimilar thickness and pipe welds to flanges. Excellent for repairs to machine bases and frames and oil pumps.

TYPICAL BASE METALS:

- Gray iron castings
- Meehanite castings
- Malleable alloy castings
- Nodular and ductile cast irons
- Compacted iron castings
- Sheroidal Cast Irons (SG castings)
- SG Ni-Resist Cast Irons

