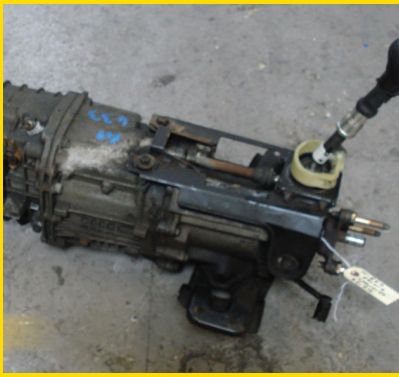
Mantenance and Repair Electrode for Contaiminated or Oil-Soaked Cast Irons

EutecTrode® 244



WELDING

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

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

EutecTrode 244 is the ideal electrode when welding unknown grades of gray cast iron, particularly when the casting is seriously contaminated with oil, sulfur, etc. EutecTrode 244 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: 53,000 psi (365 MPa)
Typical Yield Strength: 37,000 psi (255 MPa)
Typical Hardness (Rb): 80
Polarity: AC/DCEN (-) or DCEP (+, preferred)

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

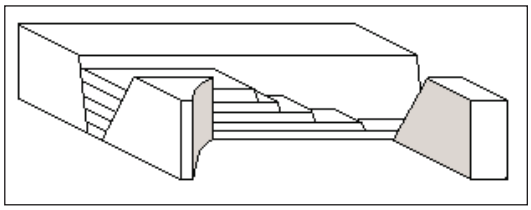
TYPICAL APPLICATIONS:

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

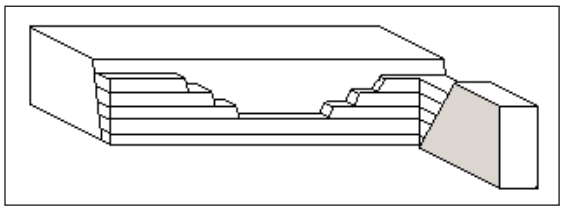
WELDING PARAMETERS:

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 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.

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