

High Quality Electrode for Welding Gray Cast Irons When Strength and
Machinability are Required

EutecTrode® 3055



WELDING

- Excellent crack resistance
- Good for thick or variable section castings
- Machines cleanly with no smearing
- Better mechanical properties than conventional cast iron rods



DESCRIPTION:

Eutectic 3055 is recommended for welding engineering-grade cast iron when mechanical properties similar to the base metal are required.

Eutectic 3055 deposits high-strength weld metal with excellent crack resistivity properties on thick-section casting. Ease of welding in all positions gives high welder appeal.

TYPICAL APPLICATIONS:

- Pump and Differential Housings
- Motor Blocks
- High Phosphorus Irons and Steels
- Heavy Section Casting Repair
- Dimensional Restoration

TECHNICAL DATA:

Current: DCEP (electrode +)

Typical Tensile Strength: 55,000 psi (380 N/mm²)

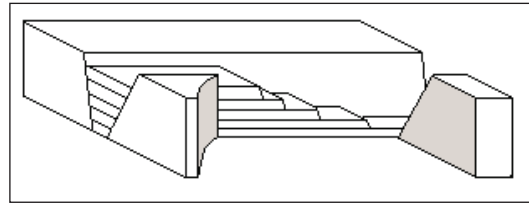
Hardness: HRB 90

Diameter	3/32" (2.4mm)	1/8" (3.2mm)
Amperage	110-120	130-140

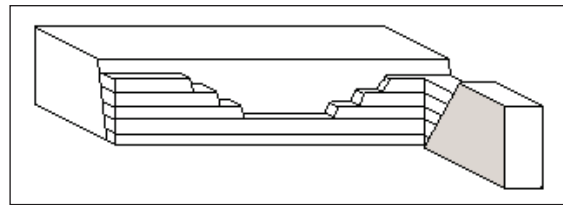
WELDING PARAMETERS:

Preparation: Clean joint and/or parts to be welding thoroughly. Terminate crack growth by drilling ¼" holes at the leading points. Preheat casting to 150-200°C, holding for 1 hour per inch of thickness. Prepare joint with Eutectic ChamferTrode® or ExoTrode® with either a single-V or double V, depending on joint thickness and accessibility. 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 available insulating material such as vermiculite, sand or fire retardant blankets.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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