



Versatile Electrode for All
Weldable Cast Irons

Xuper®

2240



- Excellent tie-in and fluidity characteristics in all-positions
- Excellent welding wash and fluidity with little or no spatter
- Unique chemistry for in-process weld cleaning and little to no spatter
- Ductile matrix imparts high crack resistance

Xuper® 2240

Xuper 2240 is an extremely versatile joining and re-build electrode specially formulated for gray, ductile, nodular and alloyed cast irons. This all-position electrode possesses a unique arc, which aids in removing harmful contaminants. Xuper 2240 deposits weld metal having a crack-resistant structure. It is easily handled, produces little to no spatter and it welds with excellent fluidity and wash. Weld deposits are machinable.

TECHNICAL DATA

Typical Values

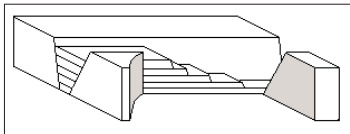
Tensile Strength:	55,000 psi (380 N/mm ²)
Yield Strength:	38,000 psi (262 N/mm ²)
Hardness:	75 HRB
Current polarity:	AC or DCEN (-)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	80-90	105-115	130-145

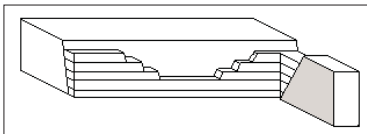
PROCEDURE FOR USE

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 ChamferTrode® or ExoTrode®. 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

- Pump Casings
- Bell Housings
- High-Strength Alloyed Cast Iron Gear Boxes
- Machine Bases
- Repairing Foundry Defects
- Motor Casings



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



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