

SHUBER E 201

CAST IRON - NON MACHINABLE



DESCRIPTION

ELECTRODE DEVELOPED FOR ECONOMICAL WELDING OF CAST IRON NOT REQUIRING MACHINABLE WELD DEPOSIT. Special coating chemistry produces superior welds on dirty oil-soaked and contaminated cast iron. Controlled penetration provides excellent bonds on heat-affected and oxidized cast iron. Ideally suited for use as bonding layer or sealer for contaminated cast iron surfaces prior to welding with machinable nickel electrodes. Recommended for repairs of machine bases and frames, exhaust manifolds, furnace grates, transmission housings, including joining cast iron to steel.

SPECIAL FEATURES

- Unique "quick freezing" deposits suppresses the formation of gases that cause porosity.
- Coefficient of expansion & elongation similar to cast iron.
- Nickel-free deposit provides perfect colour match to cast iron.

APPLICATION INSTRUCTIONS

Clean weld area and bevel cracks with SHUBER E 100. Weld with the lowest possible amperage and maintain a relatively short arc. Use stringer bead technique and do not weave. Weld short beads of 25 mm to 75 mm long, backwhipping each crater. Do not exceed 200°C (400°F) working temperature.

TECHNICAL DATA

TENSILE STRENGTH: 38 kg/mm² (56,000 psi)

RECOMMENDED CURRENT:

AC or DC (Straight or Reverse Polarity)

DIAMETER

AMPS

3.2 mm (1/8") 85 - 110

4.0 mm (5/32") 110 - 130

Tip colour: Black