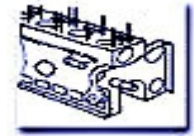


SHUBER E 206

CAST IRON - ALL TYPES



DESCRIPTION

VERSATILE ELECTRODE DESIGNED FOR WELDING ALL TYPES OF CAST IRON INCLUDING ALLOYED CAST IRON, NODULAR, MALLEABLE, DUCTILE, MEEHANITE AS WELL AS JOINING CAST IRON TO STEEL. Perfectly balanced nickel-iron core ensures an easily machinable weld deposit of high strength and superior resistance to cracking. Special elements in the coating creates a highly ionized arc with sufficient drive to penetrate even oil soaked and contaminated base metals. Applications include repair of motor blocks, transmission housings, gears, machine bases and machine parts where high strength & machinability is desired.

SPECIAL FEATURES

- Easily machinable without hard spots or inclusions.
- Crack resistant due to minimum base metal penetration.
- Permits out-of-position welding without dismantling.
- Sulphur and phosphorous stabilized.

APPLICATION INSTRUCTIONS

Bevel cracks to 70-90° vee using SHUBER E 100. Hold a short to medium arc at the lowest possible amperage. Deposit in intermittent beads to avoid localized overheating. Peen deposit to relieve weld bead stress. On subsequent layers always strike arc on the weld deposit and not on the base metal. Allow to cool slowly after welding.

TECHNICAL DATA

TENSILE STRENGTH: 48 kg/mm² (69,000 psi)

RECOMMENDED CURRENT:

AC or DC (Straight or Reverse Polarity)	DIAMETER	AMPS
	2.4 mm (3/32")	50 - 80
	3.2 mm (1/8")	85 - 115
	4.0 mm (5/32")	110 - 140

Tip Colour: Yellow