

# SHUBER E 209

## CAST IRON - HIGHLY MACHINABLE



### DESCRIPTION

UNIQUE ELECTRODE SPECIFICALLY DEVELOPED FOR COLD WELDING OF GREY CAST IRON. SPECIALLY FORMULATED NICKEL ALLOY CORE WITH SPECIAL TYPE COATING MINIMIZES PENETRATION AND BASE METAL DILUTION. Carbide formation in the microstructure is prevented resulting in dense, crack resistant deposits with ultra high machinability. Ideal for repairing cracks, cladding & build-up of machine finished parts where close tolerances are to be maintained. Can be used also for welding cast iron to steel. Applications include repair of cast iron engine blocks, pump housings and other thin-walled parts as well as build up of missing sections.

### SPECIAL FEATURES

- Outstanding machinability with no hard spots.
- Positively no cracking due to excellent elongation properties.
- Applicable for in-place welding without dismantling for heavy sections.
- Good colour match to cast iron.

### APPLICATION INSTRUCTIONS

Clean weld area. Bevel cracks to 70-90° vee using SHUBER E 100 for optimum results. Use a short to medium arc at the lowest possible amperage. Use stringer beads or slight weaving technique and skip weld to avoid localized overheating. Peen weld deposit to relieve stresses. Allow to cool slowly after welding.

### TECHNICAL DATA

TENSILE STRENGTH: 45 kg/mm<sup>2</sup> (65,000 psi)

RECOMMENDED CURRENT:

AC or DC (Straight or Reverse Polarity)

DIAMETER      AMPS

2.4 mm (3/32")    35 - 75

3.2 mm (1/8")    55 - 110

4.0 mm (5/32")    80 - 130

Tip Colour: Red