



Specially Designed for Dirty Cast Iron – The Problem Solver To Use When All Others Fail

AC/DC REVERSE POLARITY (ELECTRODE+)

GENERAL CHARACTERISTICS:

Unique flux coating on alloyed core wire produces dense, strong, crack-resistant welds on all types of cast iron. Especially good for contaminated, old, oil-soaked, dirty base metal. Also recommended for joining cast iron to steel. Use on gray, ductile, Meehanite, and nodular cast iron. Deposits are machinable.

APPLICATIONS:

Use on sewer pipe, machine bases, transmission or gear housings, sprockets, repair of or build-up on gears, and any repair of cast iron to steel.

TECHNICAL DATA:

Tensile Strength	up to 75,000 psi (517 N/mm ²)			
Hardness	Brinell 210			
Current	AC or DC Reverse Polarity			
Amperage	40-70	70-110	90-130	110-170
(in)	3/32"	1/8"	5/32"	3/16"
(mm)	2.5	3.25	4.0	5.0

PROCEDURES:

On heavy sections, remove worn, cracked metal, and bevel joint using AmAlloy 670 or a grinding wheel. When repairing cracks, drill "stop" hole at either end to prevent spreading while welding. On very heavy sections, preheat to approximately 400°F. Use short stringer beads for root pass and peen lightly after removing slag. Use a short to medium arc and the lowest amperage possible to minimize base metal over-heating. When breaking arc, always back whip into weld crater. Weaving two times rod diameter is acceptable for cover beads on multi-pass work. Weld joints should be allowed to slow cool for maximum strength and machinability.

Manufactured by **AmAlloy Industries®**
To Order - Call: **507-373-1677** or **800-735-3040**
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www.amalloy.com