

**DESCRIPTION**

General purpose flux-coated rod for **assembling** and **rebuilding** grey and/or malleable cast iron parts **with a torch**. Excellent for cast iron-steel dissimilar assemblies.

**CHARACTERISTICS**

- **Ideal for welding thin sections**
- Dense and porosity-free deposit
- Can be used in position
- Machinable deposit
- Excellent color match with base metal
- No other soldering flux required

**TYPICAL APPLICATIONS**

Aluminized steels exhaust manifolds, machinery bases, gear teeth, motor units, molds, pump housings, aluminized muffler pipes; rebuilding of used or missing sections, porosity fill, foundry defects, cast iron antique parts, etc.

**PROCEDURE**

Remove any trace of oil, grease and dirt from the weld surface. Gouge the thick sections and the cracks with **Soudotec 212 SP**. Preheat the welding area evenly to about 427°C (800°F). With a slightly oxidizing flame, heat the rod tip to generate a liquid flux on the work piece. Melt the filler metal one droplet at a time and spread on the bottom of the joint while moving the flame back and forth. Cool slowly.

**MECHANICAL PROPERTIES**

Tensile strength: 45 000 psi (310 MPa)  
Hardness: 200 - 250 BH

**WELDING PARAMETERS**

Diameter: 5.0 mm (3/16") 4.0 mm (5/32")  
Bonding temperature: 760 – 871°C (1400 – 1600°F)  
Type of flame: Slightly oxidizing

Bare rod also available: **Soudotec 155B**

Rev.: 7\_01

*Specialized welding alloys and technology. For technical assistance or for ordering:*