

Soudotec 168

AC/DC+

CAST IRON**DESCRIPTION**

Specialty-coated electrode with a **low-carbon steel core** designed for **cost-effective** welding of dirty, contaminated and burnt cast irons. **Excellent for depositing buttering coats** before welding with machinable cast-iron electrodes.

CHARACTERISTICS

- **Excellent all-position weldability on any quality cast iron**
- Good anchorage on dirty and oily cast irons
- Excellent on AC power supply
- Rust deposits with good color match on cast irons
- Good mechanical resistance
- Machinable deposits by grinding only

TYPICAL APPLICATIONS

Foundry oven parts, sewer pipes, exhaust manifolds, smelting irons, oil and grease-saturated cast parts, oven racks, crankcases, farm machinery parts, etc.

PROCEDURE

Clean weld area removing oil, dirt and all impurities. Bevel with **Soudotec 212 SP** or **Soudotec G12**. Use hot or cold welding technique (p.01-02 and 01-03). Keep a short arc. Peen each bead for stress relief. Let cool down slowly.

MECHANICAL PROPERTIES

Tensile strength: 65 000 psi (450 MPa)
Hardness: 350 - 400 BH

WELDING PARAMETERS

Diameter:	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	100 – 140 A	75 – 110 A

Rev. : 7_01

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