

 **Soudotec MC 8189G** DC+

CAST IRON

DESCRIPTION

Gas shielded flux-cored wire **without slag** with a special ferro-nickel formulation for **joining, building up** and **repairing** a large variety of cast iron. Excellent for cast iron and steel dissimilar assemblies.

CHARACTERISTICS

- **Excellent weldability and arc stability**
- Dense and machinable deposit (with carbide tools)
- Excellent mechanical properties
- No slag to remove
- Good bead appearance
- Excellent for thick cast iron parts and for different thickness parts
- High deposit rate

TYPICAL APPLICATIONS

Cast iron and steel dissimilar assemblies, thick cast iron parts, housings, smelting parts, press, gear teeth, machinery bases, cast iron molds, etc.

PROCEDURE

Clean the work piece and chamfer with **Soudotec G12** or **Soudotec 212 SP**, if needed. Maintain a short arc and deposit a stringer. Peen the beads to reduce tension and fill all craters at the beginning and end of each pass, if necessary. Preheating between 200 - 260°C (400 - 500°F) is recommended for thick cast iron parts. Use hot or cold welding technique (p.01-02 and 01-03).

MECHANICAL PROPERTIES

Tensile strength: 80 000 psi (550 MPa)
Hardness: 180 BH

WELDING PARAMETERS

Gas: Argon - CO₂ mixture
Diameter: .045" (1.2 mm) (others diameters on request)
Amperage: 180 - 250 A
Voltage: 20 - 26 V
Stick-out: 1/2" - 1"
Gas flowrate (c.f.h): 40 - 50
Packaging: 2.3 kg (5 lb), 4.5 kg (10 lb) and 15 kg (33 lb) spool

Also available in electrodes: **Soudotec 189 SP/BF**

Rev. : 7_01

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