

Xyron 224

Manual Metal Arc Electrode For Machinable Welds For Cast Irons

DESCRIPTION

Special electrode offering optimum machinability for all cast irons, flat beads without under-cutting. The first Castolin low ampelelectrode for welding grey cast iron with metal transfer by fine droplets, offering optimum machinability. No under-cutting (important for new parts in pre-machined cast iron). No preheating required, enhanced fluidity, easy to remove slag. Ideal for overlaying and for buttering layers as preparation for bronze electrodes.

Product Details

- Excellent deposition characteristics with Very good machinability.
- Good positional welding with low amperage welding current
- Homogeneous deposit structure with low dilution.

APPLICATIONS

Applications include machine tool carriages, bearing supports, crankshaft cases, cable drums, slide ways, chain wheels, cog wheels, bronze or Grey cast iron turbine blades, eroded turbine housings, gaskets, valve seats, electric motor cases and flanges, etc.

PROCEDURE FOR USE

Preparation: Ensure that all areas to be welded are free from contaminants, remove casting defects such as sand inclusions and blowholes and damaged or fatigued base material. For the repair of cracks prepare, by gouging suitable «U» or «V» type joint-design, depending on wall thickness, using ExoTrode.

Preheating: For small and intricate castings, preheating between 200 - 300°C. may be necessary. For large and complicated sections, where preheating cannot be successfully applied (avoid local preheating) maintain the workpiece at ambient temperatures throughout the repair operation by allowing each weld bead to cool before commencing subsequent welds.

Welding technique: For non-preheated parts, select lowest possible amperage in order to minimize heat input and employ a balanced welding technique. Hold a near vertical electrode angle and maintain a short arc length, deposit stringer beads 4-3 cm in length followed by peening (do not peen thin section components). Maintain the workpiece temperature close to ambient temperature, allow each weld bead to completely cool prior to subsequent weld. Ensure that each weld pass is completely free from slag, defects, etc. Preheated parts should be cooled at a slow, even rate down to room temperature.

TECHNICAL DATA

Tensile strength: 475 N/mm² (69,000 psi)

Typical hardness: 195HB

Current polarity: AC/DC (-)

DIAMETER	AMPERAGE
2.5mm	50-80
3.2mm	70-110
4.0mm	90-130

Note: For optimum result use the lowest amperage practical