

Xuper 2240

Manual Metal Arc Electrode For Repair And Maintenance Of Contaminated Cast Iron

DESCRIPTION

A high nickel alloy electrode producing low-heat-input deposits which are highly crack resistant and fully machinable. The electrode is designed with an electroplated core wire of controlled thickness to ensure a low electrical resistivity. This avoids overheating of the electrode, and ensures a unique metal transfer characteristic for low dilution and controlled metallurgical structure, with spherical graphite formation for high resistance to weld metal cracking. The special arc characteristics also allow positional welding even on contaminated surfaces. For the fabrication and repair of flake graphite and nodular cast iron where ease of welding, low heat input and high crack resistance are important. Also suitable for joining cast iron to carbon steels and low alloy steels.

Product Details

- Superior positional weldability with Nodular graphite deposit for crack resistance, strength and colour match
- Low heat input, smooth metal transfer
- Absence of electrode overheating
- Special arc characteristics for contaminated surfaces

APPLICATIONS:

Assembly of cast iron to steel, machine bases, pass is completely free from slag, defects, pump casings, gear housings, flywheels, foundry etc. Preheated parts should be cooled at a defects, lathe beds and ways, pulleys, dies, levers, slow, even rate down to room temperature. pump housings, differential housings, gears allow each weld bead to completely cool prior and gear boxes, engine blocks, turbine housings, to subsequent welds. Ensure that each weld flanges, hydraulic cylinders.

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 pre-heating 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 minimise 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 welds. 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: 346 N/mm² (50,000 psi)

Typical hardness : 170HB

DIAMETER	AMPERAGE
2.5mm	60-90
3.2mm	90-120
4.0mm	120-150

Note: For optimum result use the lowest amperage practical