

Xuper 22^{*}33N

Premium Nickel-Iron Electrode For Superior Cast Iron Welding With Highest Tensile Strength

DESCRIPTION

Xuper 2233N is a low-amperage, cored wire, flux-coated electrode for welding the widest range of cast irons as well as for welding cast iron to steel. Deposits are highly crack-resistant with superior machinability. Improved weldability and wash characteristics result in weld beads that are flat, even, and finely rippled. The advanced core wire prevents overheating at rated amperage reducing stub loss while Maintaining weldability. The smooth stable arc has great strike and re-strike characteristics with minimal spatter and fuming.

Product Details

- All position, AC/DC electrode for joining, build-up and overlays
- Durable, crack-resistant welds with great machinability
- High quality core wire reduces overheating and flux breakdown, meaning less stub loss
- Good for nodular and ductile cast irons, sections under restraint and dissimilar joints of cast irons and plain steels can be used on grey, malleable, meehanite, SG, Ni-resist Cast iron

APPLICATIONS

Ideal solution for a variety of cast iron repairs under demanding conditions, joints under severe restraint, dissimilar thickness and pipe welds to flanges. Excellent for repairs to machine bases and frames and oil pumps.

PROCEDURE FOR USE

Preparation: Clean joint and/or parts to be welding thoroughly. Terminate crack growth by drilling ¼" holes at the leading points. Preheat casting to 400°F holding for 1 hour per inch of thickness. Prepare joint with ExoTrode®. Joints below 1" should be beveled to a V-profile; Over 1" can be beveled to either a single or double J-profile. Allow a root opening of 8/1" for full penetration welds.

Technique: Deposit short runs no longer than - 2in. and moderately peen 2nd and subsequent passes. For long cracks in heavy castings use either a cascade and/or block deposition sequence.

Post Welding: Slow cool after welding using insulating material such as vermiculite or heat-retardant blankets.

TECHNICAL DATA

Tensile strength: 496 N/mm² (72,000 psi)

Typical hardness: 87-90 HB

Current polarity: AC/DC (-)

DIAMETER	AMPERAGE
2.5mm	95-100
3.2mm	110-130
4.0mm	145-160

Note: For optimum result use the lowest amperage practical