

Xuper Xyron 242

Manual Metal Arc Electrode With Superior Machinable For Cast Iron Joining

DESCRIPTION

Castolin 242 is a manual metal arc electrode with a special coating designed for hot welding of grey cast iron, matching the cast iron base metal. According to the heat treatment, the welded deposit can become ferritic or pearlitic-ferritic. Recommended for spheroidal (nodular) graphite cast irons.

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, slideways, 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 all areas to be welded are free from contaminants. Remove casting defects such as sand inclusions and blowholes. For crack repair, prepare by gouging suitable "U" or "V" type joint-design using ExoTrode

Preheating: Mandatory. For small parts, preheat between 300° C and 400°C. For larger parts, preheat at 600°C.

Heat Treatment:

Ferrite Treatment: Annealing at 920°C for 2 hours, reduce temperature to 700°C over 5 hours.

Ferrite-Pearlitic Treatment: Annealing at 880° C– 920°C for 2 hours, reduce temperature to 450°C, then reheat at 550°C for 3.5 hours. Cooling: In oven, ensure no temperature differences between areas of the part during cooling.

TECHNICAL DATA

Tensile strength: **360 N/mm²** (52,000 psi)

Typical Hardness: 120 HB

Current polarity: AC/DC (-)

DIAMETER	AMPERAGE
2.5mm	120-160
3.2mm	160-190
4.0mm	200-240

Note: For optimum result use the lowest amperage practical