



## EAGLE 194 GS

Fully machinable solid cast iron wire for welding cast iron.

### APPLICATIONS

Low temperature repairs on all types of cast iron, especially where soft deposits are important. Ideal for repairs on engine blocks, pump housings, machine bases and joining cast iron to steel. Excellent alloy for build-up on cast iron.

### PROCEDURE

DC reverse polarity (+). Prepare and clean weld areas. Groove out cracks using **EAGLE 188**. Use lowest effective amperage while maintaining a medium arc length. Short deposits are recommended (1" - 1 1/2") using the skip weld method to reduce heat input. Recommended pre-heat is 600<sup>0</sup>F - (315<sup>0</sup>C) - 900<sup>0</sup>F - (482<sup>0</sup>C). Peening while hot will help reduce stresses. Allow the casting to cool slowly.

### GENERAL CHARACTERISTICS

The **EAGLE 194 GS** is a high nickel all position wire that produces porosity free soft welds.

### TECHNICAL DATA

Hardness: BH	150 - 160		
Current:	DC Reverse (+)		
Sizes: (IN)		.035	.045
(MM)		0.90	1.20
Volts:		20 - 26	26 - 32
Amperage:		150 - 180	180 - 200
Gas Flow:	35 - 40 cu feet per hour		
Shielding Gas:	100% Argon		
Shielding Gas:	75 % Argon - 25% Helium		
Spool Size:	4.5 Kg - 10 Lbs.		

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