



EAGLE 194

Fully machinable electrode for welding cast iron.

APPLICATIONS

Superior low temperature electrode that is machinable for welding on engine blocks, heads, housings, transmissions and gears. Can also be used for build-up and joining steel to cast iron.

PROCEDURE

AC or DC straight polarity (-). Prepare and clean weld area. Groove out cracks using the **EAGLE 188**. Use lowest effective amperage while maintaining a short to medium arc length. Short weld deposits are recommended (1" - 1 1/2") using the skip weld method to reduce heat input. Peening while hot will help to reduce stresses. Allow casting to cool slowly.

GENERAL CHARACTERISTICS

The **EAGLE 194** is a high nickel, all position low heat electrode that produces porosity free weld deposits on cast iron.

TECHNICAL DATA

Tip Color:	Red			
Hardness: BH	Approximate 160			
Current:	AC - DC Straight (-)			
Sizes: (IN)		3/32	1/8	5/32
(MM)		2.50	3.25	4.00
Amperage:		40 - 75	70 - 115	120 - 180

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