



# 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**

Use AC or DC Straight [-] Polarity. Prepare and clean the 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" - 1½") 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 Colour: Red  
Hardness: (BH) Approx. 160

## **WELDING PARAMETERS**

Current:	AC or DC Straight [-] Polarity			
Sizes:	Inches	3/32	1/8	5/32
	mm	2.50	3.25	4.00
Current:	40 - 75	70 - 115	120 - 180	



≡ HIGH QUALITY WELDING PRODUCTS ≡

10077 - 166 STREET, EDMONTON, ALBERTA T5P 4Y1 • BUS: (780) 481-8082  
FOR TECHNICAL ASSISTANCE CALL US TOLL FREE 1-800-447-1415