



EAGLE 180

A High Strength Alloy For Repairs On Cast Iron

APPLICATIONS

This electrode can be used to weld gray, ductile and nodular cast iron. Excellent for build-up or joining on repairs to engine blocks, housings, sprockets, transmission housings, gear teeth and machine bases. Deposits are fully machinable.

PROCEDURE

Use AC or DC Reverse [+] 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" - 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 180** is a high strength special alloyed core electrode that will produce porosity free welds on all types of cast iron.

TECHNICAL DATA

Tip Colour: Dark Green
Hardness: (BH) 200

WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes:	Inches	3/32	1/8	5/32
	mm	2.50	3.25	4.00
Amperage:	35 - 70	70 - 110	120 - 130	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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