



EAGLE 195 FGS

Full Machinable Flux Cored 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, gears, pump housings, sprockets, machine bases and joining cast iron to steel. An excellent alloy for build-up on cast iron.

PROCEDURE

Use DC Reverse [+] 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. Recommended pre-heat is 600° F - (315° C) - 900° F - (482° C). Peening while hot will help to reduce stresses. Allow casting to cool slowly.

GENERAL CHARACTERISTICS

The **EAGLE 195 FGS** is an all position wire that produces porosity free soft welds..

TECHNICAL DATA

Hardness: (BH) Approx. 190 - 200
Current: DC Reverse [+] Polarity

WELDING PARAMETERS

Sizes:	Inches	0.35	0.45
	mm	0.90	1.20
Volts:		20 - 26	27 - 29
Amperage:		150 - 180	220 - 250
Gas Flow:		35 - 40 CFH	
Shielding Gas:		98% Argon / 2% Oxygen	
		75% Argon / 25% CO ₂	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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