



EAGLE 193

Full Machinable Electrode For Welding Cast Iron

APPLICATIONS

Superior low temperature electrode for repairs on all types of cast iron especially where soft deposits are important. Ideal for repairs 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 193** is a high nickel, all position low heat electrode that produces porosity free weld deposits on cast iron.

TECHNICAL DATA

Tip Colour: Gold
Hardness: (BH) Approx. 160

WELDING PARAMETERS

Current:	AC or DC Straight [-] Polarity			
Sizes: Inches	3/32	1/8	5/32	3/16
mm	2.50	3.25	4.00	5.00
Amperage:	40-75	70-115	120-150	150-180



≡ HIGH QUALITY WELDING PRODUCTS ≡

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