

T-Cast

Characteristics and Applications:

T-Cast is a low hydrogen type electrode with mild steel core rod. It is designed for the welding of cast iron when machinability of deposited metal is less considered. The welding can be done with stable arc and less porosity. It has a wide application due to its low cost and excellent weldability. It is suitable for repairing cracks or breaks in cast iron.

Notes on usage:

1. Clean up the contaminations on the base metal and welding seam so as not to derogate the weld metal quality from crack and porosity.
2. Heat the welding portion to fully evaporate oil, liquor or solvent on it; the recommended temperature is at around 400~500°C.
3. Maintain short arc length. Moving range should be controlled within 3 times of the wire's dia when you are welding with weave method.
4. Use intermittent weld and keep arc length short (no longer than 3") or otherwise the prolonged heating might cause crack on joint edge. Symmetrical intermittent weld should be applied to multi-layer welding so as to balance the heat stress.
5. Based on the metal's type, shape, and size, pre-heating and slow cool-down is sometimes required.
6. To alleviate shrinking stress, proceed peening on and off at the temperature above 540°C after welding to prevent crack or distortion.

Typical chemical composition of core wire (wt%):

C	Mn	Si	P	S
1.7	0.40	1.45	0.020	0.003

Welding position:



Sizes and recommended current range(AC or DC<+>):

Diameter (mm)	3.2	4.0
Length (mm)	350	350
Amps	70-110	100-150

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