



## **Weltrode WC 8300 AC-DC**

**Premium Electrode For Welding Cast Iron To Cast Iron To Steel With Maximum Machinability**

### **Why Do Welders Choose Weltrode WC 8300 AC / DC**

Weltrode WC 8300 is an all position AC/DC graphitic coated electrode, designed specially for cast iron maintenance to be used for the on the job repairs eliminating the necessity of dismantling the equipment producing porous-free machinable weld deposit giving highest reliability

### **Special Features**

- ✦ High reliability on contaminated oil soaked and dirty cast irons.
- ✦ Welds any grade of cast iron including meehanite, nodular and spherodial cast iron
- ✦ Specially alloyed coating materials and fluxing agents produce porous free welds
- ✦ The flux coating of Weltrode WC 8300 does not contain “ Barium “ thus eliminating hazardous fumes during welding
- ✦ Perfect color match with the base metal
- ✦ All position welding possible



## Typical Properties

<b>Tensile Strength</b>	<b>62,000 Psi</b>
<b>Hardness</b>	<b>Brinell 180</b>
<b>Yield Strength</b>	<b>47,000 Psi</b>
<b>Elongation</b>	<b>20%</b>

## Applications

Ideal for machine base, gears, sprockets, flasks, transmission mountings , engine blocks casting and structures such as pedestal, frames, housings and casting shapes of all types. Used also for joining cast iron to steel

## International Specification

AWS / ASME A5.15 - CLASS E Ni CL

DIN 8573: E NiBG1

## Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	60	90	110
Maximum Amperage	90	120	140

## Welding Techniques

Remove all rust, scale from the surface to be welded. Adjust amperage within recommended range and deposit electrode maintaining a short to medium arc length. Tilt the electrode 30 degrees in the direction of travel. Use stringer bead or moderate weave technique and back-whip all craters. Use reverse polarity on DC.