# Weltrode WC 8400 AC-DC

## Specially Formulated Electrode For Building Up Oil Soaked Cast Iron Draw Dies Without Porosity (Draw Surfaces)

## Why Do Welders Choose Weltrode WC 8400 AC / DC

Weltrode WC 8400 is an all position AC/DC coated electrode low hydrogen electrode, for building up directly on cast iron base metals. The unique formulation of this electrode provides positive arc stability and superior high performance weldability.

## Special Features

- Unique chemistry of Weltrode WC 8400 produces homogeneous porosity free weld deposits.
- Can be used for build up of wearing draw surfaces on all types of Cast iron draw dies Excellent Results on nodular, ductile and special cast alloys.
- The deposited metal shows low hardness but becomes moderately hard
- Deposits are long wearing and develop a high polish while in service.

## Typical Properties

| | |
|---|---|
| **Hardness** | **RC 18-20 as welded**<br>**RC 28-30 work hardened** |

WELTRODE®
The Welding Technology

## Application

Used on all types of Cast Iron Draw dies including gray, nodular, ductile and special cast alloys.

Used where similar hardness is required on draw dies in areas like draw surfaces without porosity

Excellent sliding properties prevents formation of high points on draw durfaces

## Recommended Amperage Settings

| Diameter (mm) | 3/32 (2.5) | 1/8 (3.25) | 5/32 (4.0) |
|---|---|---|---|
| Minimum Amperage | 60 | 80 | 100 |
| Maximum Amperage | 80 | 100 | 130 |

## Welding Techniques

Remove all rust, scale, drawing compound and oil from the surface to be welded. Preheating to 150 deg C is effective though in many cases not necessary. It is recommended to use as low a current as possible. Peen rapidly to help relieve stresses. Clean off slag between passes.

Use DC Reverse Polarity