Weltrode WC 8350 AC-DC

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

Why Do Welders Choose Weltrode WC 8350 AC / DC

Weltrode WC 8350 is an all position AC/DC graphitic coated electrode depositing very high nickel alloy weld metal, designed to produce crack-free machinable deposits on all grades of cast iron. Particularly suited to contaminated iron high in phosporus. Electrode minimizes overheating in use.

Special Features

- Highly balanced Nickel content to ensure crack resistance and machinable welds. The problem of high carbon weld metal deposits is avoided by using Weltrode WC 8350 which produces finely divided graphite no porosity and a readily machinable deposits.
- The special chemistry of Weltrode WC 8350 enables it to weld any grade of cast iron present in the world making it the most versatile electrode.
- Smooth and spatter free operation providing high quality porosity free weld.
- The tested blend of elements in the coating of Weltrode WC 8350 enables it to weld in contaminations.
- Welds Cast iron to Steel
- Pass on Pass welding without slag removal possible
- The flux coating of Weltrode WC 8350 does not contain “ Barium “ thus eliminating hazardous fumes during welding
- Perfect color match with the base metal
- All position welding possible

WELTRODE®
The Welding Technology

Typical Properties

Tensile Strength	**75,000 PSI**
Hardness	**Brinell 180**
Yield Strength	**48,000 PSI**
Elongation	**20%**

Applications

Weld all grades of grey cast iron, alloy cast iron such as mehanite, the ductile iron including nodular, malleable and spheroidal graphitic iron.

Weld furnace grates, burners, sewer pipe, cast iron flanges and fittings, boilers, stoves, and other components subject to temperature rise in service.

Weld iron containing nickel or copper and also those with added phosphorous.

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

Clean surface if possible. Otherwise weld through contamination. 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 DC Reverse (+)