



Weltrade 7130 AC-DC

Premium High Strength Iron Based Non Machinable Electrode For Contaminated Cast Irons .

Special Features

- * Good Results On Contaminated , Oil Soaked And Heat Oxidised Cast Irons .
- * High Resistance To Cracking .
- * Specially Formulated Flux Produces High Arc Force To Flush Away Impurities And Give Porosity Free Welds .
- * Excellent Colour Match With The Base Metal.

International Specifications

AWS/ASME A 5.15 Est

DIN 8573: E Fe-1

ISO 1071: E Fe

Typical Properties

Tensile Strength	60000 PSI
Yield Strength	46000 PSI
Hardness	39 HRC

Applications

- * Ideal For Repair Of Cracked Machine Bases , Burned Furnace Grates , Pedestals , Oil Pans , Frames And Housings , Dies , Agricultural Equipment , Build-Up Of Abrasion Worn Areas , Pump Housings And Low Quality Cast Iron Etc .
- * Used Also For Joining Cast Iron To Steel .

Recommended Amperage Settings

Diameter	3/32(2.5)	1/8(3.15)	5/32(4.0)
Minimum Amperage	50	70	90
Maximum Amperage	80	120	130

Welding Techniques

Remove All Rust And 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 In The Direction Of Travel .Use Short Beads Which Are Widely Separated For Ease Of Heat Dissipation . Use Reverse Polarity On DC/AC .

