



Weltrode 7220 AC-DC

Premium Graphite-Basic Coating Electrode For Cold Welding Of Grey , Malleable And Nodular Cast Iron .

Special Features

- * Heat Affected Zone And Weld Metal Easily Machinable .
- * High Nickel Content Provides Resistance To Cracking With Excellent Machinability .
- * Specially Formulated Flux Produce Porus Free Welds .
- * Non Conductive Coating Produces Strong Arc Ideally For Dirty Contaminated Cast Irons .
- * Easy Arc Striking And Restriking , Stable Arc , Smooth Bead Surface .

International Specifications

AWS/ASME A 5.15: E NiCl

DIN 8573: E Ni BG 11

Typical Properties

Tensile Strength	53000 PSI
Yield Strength	36000 PSI
Hardness	150 Brinell

Applications

- * Electrode For Welding Cast Iron With Lamellar Graphite , White And Black Heart Malleable And Nodular Cast Iron . Applications Include Machine Bases , Pump Casings , Gear Boxes , Transmission Mountings , Engine Blocks 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	60	90	110
Maximum Amperage	90	120	140

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 Stringer Bead Or Moderate Weave Technique And Back-Whip All Craters .

Good Results On Both AC And DC Machines



The Finest Maintenance Alloys Developed In America

