AMTEC 122 CAST IRON AC/DC REVERSE ELECTRODE

General Characteristics

A nickel-iron type core wire, with an extruded coating,makes this cast iron electrode good for all position welding of most cast irons. This electrode produces more joining strength than the full nickel electrodes, but will not give as machinable a deposit as the full nickel electrodes, such as Amtec 3 and Amtec 133. It is designed for low cost repair on cast iron.

Tensile Strength	-	80,000 PSI
Yield Strength	-	20,000 PSI
Elongation	-	20%
Hardness (HB) Brinell	-	Approx. 200-220

Diameter (Inch)	Diameter (MM)	Amps(approx.)
3/32	2.5	35-80
1/8	3.25	65-120
5/32	4.0	75-140

Procedure

Although many cast iron parts do not need preheat, it is recommended that a preheat of 600°F be used on large cast iron sections. Use stringer beads when welding and if multiple layers are needed, remove slag between passes. Use proper welding and if multiple layers are needed, remove slag between passes. Use proper welding preparation procedures, as with all cast irons, by cleaning and gouging with Amtec 8 where possible. Always slow cool cast iron parts after welding.

Application

Amtec 122 is used to weld cast irons and nodular iron, and to join these irons to steel and other ferrous and non-ferrous materials. It is also used for heavy sections of high strength cast iron. It is used to weld high phosphorus irons, ductile iron and high nickel alloy cast irons.

Tip Color – Green