

AMTEC 330 CAST IRON AC/DC REVERSE ELECTRODE



General Characteristics

A one of a kind, NEW “Tri-metal” cored cast iron electrode. The high efficiency weld metal transfer totally eliminates overheating of the electrode. This NEW proprietary copper-nickel-iron deposit chemistry yields the ultimate combination of softness, ductility and tensile strength.

Tensile Strength	-	70,000 PSI
Yield Strength	-	54,000 PSI
Elongation	-	30%
Hardness (HB)	-	Approx. 176
Brinell		

Diameter		Amps(approx.)
(Inch)	(MM)	
3/32	2.5	50-90
1/8	3.25	70-100
5/32	4.0	100-130

Procedure

It is always recommended that the work piece be cleaned of heavy grease, oil and dirt. We also recommend the use of Amtec 8 gouging electrode to prepare the crack for welding, rather than using a grinding disc, wherever possible. Weld with a short arc keeping the electrode at a steep angle. Peen the weldment after each pass while the part is still hot to help relieve the stress. Use stringer beads and short welds, no longer than 1 ½ inches. Slow cool after welding to prevent cracking.

Application

Amtec 330 is very good for joining of grey irons and welding steel to cast iron. It is used to repair castings where machinability is an important factor. The high deposition rate of this electrode creates an extremely narrow heat affected zone. This feature is suitable for all weldable cast irons that require post weld machining. The microstructure of this electrode is of an iron-nickel-copper austenite with finely distributed graphite.