

Addifix 890

THE MACHINABILITY CHAMPION FOR CAST IRON WELDING (AC/DC+)

Tensile Strength:	50,000-60,000 PSI		
Elongation:	35-45 percent		
Hardness:	160 brinell		
Diameters:	3/32	1/8	5/32
Amperages:	90	105	115

The most versatile and advanced cast iron electrode available combining high strength resistance to cracking and exceptional machinability. The new super stabilizer in the coating improves the arc-transfer giving a “spray-type” deposit. Can be “weaved” with no slag inclusion.

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- Newest electrode developed for cold welding of all cast irons.
 - Joins casts iron to steel.
 - Maximum possible machinability, strength and ductility.
 - Unique new super stabilizer in the flux improves arc transfer with a *spray type* deposit.
 - Run pass over without stopping to chip slag and without porosity.
 - Extremely fast buildup
 - No undercut.
 - Excellent results on thin as well as thick parts.
 - May be run on DC- to deposit a flatter bead contour

MADE IN USA

Typical Industrial Application: Glass molds, motor blocks, castings machine bases, arms, levers, cams, trunions, gears, frames, valve seats, housings, thin sections and build-up of missing sections.

Note: Use only on clean cast iron. To use on dirty, oily cast iron, seal off the contaminants by applying a base layer of ADDIFIX 880. ADDIFIX 890 may then be applied to achieve a deposit of maximum machinability.

For Best Results: Always use short (2 inch maximum) stringer beads in a skip welding pattern. Keep the weld area as cool as possible by quenching with a wet rag. Always intensively, peen the deposited weldment after completing a bead. Veeing with 120 improves weldment strength and seals the cast iron surface for better bonding.