

CasTec 3055

Manual arc welding electrode

More than 100 years' experience in finding solutions for your business.

Application: Cast iron joining and overlaying

DESCRIPTION

CasTec 3055 is a specially balanced nickel/iron alloy coated electrode designed for welding a great variety of cast irons. Deposits are dense and free of cracks.

The FrigidArc coating with strong drive produces an easy-to-maintain arc. CasTec 3055 can be deposited in all positions: overhead, vertical, horizontal or flat.

It is recommended for high volume welding because of the alloy's easy handling and rapid deposition capabilities.

FEATURES

Weldability - CasTec 3055 provides improved weldability, smoother metal transfer, excellent wash and good LOCV AC stability, complete and quick releasing slag.

Deposits have an attractive rippled appearance. CasTec 3055 has rapid deposition characteristics with little or no spatter.

Versatility - CasTec 3055 can be used for machineable welding of a wide range of cast irons, from thin to heavy sections, filling in holes and defects and for joining cast iron to steel.

Crack Resistance - The unique alloy elements in the weld deposit make this alloy extremely resistant to cracking and porosity as found in castings involving hydrostatic pressure and joints under restraint.

Machineability - Welds are easily machineable without hard spots or inclusions.

Tip Colour Red

Wire equivalent ENiDotec DO23

TeroMatec OA223

PRINCIPAL APPLICATIONS

CasTec 3055 is formulated for use on machine bases, pump housings, transmission cases and gears where a dense, machineable, crack-free deposit is needed. Additional applications include jacketed castings, cast and malleable fittings, motor blocks and housings, etc.

TECHNICAL DATA

Mechanical properties

Tensile Strength MPa	380
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Base Metals

Recommended for welding alloy cast irons as well as steel to cast iron.

OPERATING PARAMETERS

Preparation

Thoroughly clean weld area, removing all scale, grease, dirt, inclusions, moisture or any other contaminants. Bevel cracks and sharp corners (and other stress raisers) using Xuper ExoTrod.

Preheating

In many cases the welding can be done without any preheat (interpass temperature approximately 50oC maximum) though proper preheat may be required for some complex castings, to assist welding.

Welding parameters

Dia. mm	3.2	4.0
Current A	90-135	115-150

Welding polarity AC/DC

Welding positions



Welding technique

Strike initial arc on clean scrap steel and carry over to weld area. Maintain a short to medium arc at the lowest feasible amperage. Use stringer beads and weaving, if used, should be restricted to 2 x electrode diameter. Back whip craters. Lightly peen hot weld beads to reduce stresses. Remove slag between passes. Cover finished part, in order to retard cooling.

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