

HABCO CI 8060 (S)

ECONOMICAL NICKEL-IRON ELECTRODE FOR WELDING CAST IRON

FEATURES

A nickel-iron type electrode for welding cast iron in all positions. **HABCO CI 8060** produces high strength, crack resistant and porosity free welds on all types of cast iron. Arc is smooth and stable even when using AC. Weld puddle fluidity is easily controlled and wetting action, even on dirty castings is exceptional. Deposits are machinable.

APPLICATIONS

HABCO CI 8060 can be used on grey malleable and ductile castings. Successful repairs on engine blocks, manifolds, gear housings, transmission cases and gear teeth. Ideal for producing high strength welds when repairing thick castings, joining cast iron to steel and repairing high strength castings.

INSTRUCTIONS

Clean and prepare weld zone. Vee out cracks using **HABCO MX 222**. Use skip weld technique on complicated castings. To minimize heat input, limit bead length to 1-1 1/2". Maximum inter-pass temperature should be maintained at 200°F (93°C). Chip slag between passes and peen lightly using ball end of a ball peen hammer.

Tensile Strength: up to 65,000 Psi (46 kg/mm²)

Elongation: up to 20%

Hardness: Brinell 220

Current: AC or DC +

Amperage:	60-90	80-115	110-140	125-160
Diameters: (in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0

• **Conforms to AWS A5.15 ENiFe-CI**