

HABCO CI 885

ECONOMICAL ELECTRODE FOR DIFFICULT TO WELD CAST IRONS

FEATURES

HABCO CI 885 produces high strength, non-machinable deposits that have a very close color match to cast iron. It can be operated efficiently in all positions and is typically used on heavy sections such as machine bases.

APPLICATIONS

Welding of castings that are impregnated with oil, grease, paint or other contaminants that make repairs with nickel electrodes impossible. It is often used to repair castings that have been burned, such as furnace grates and other problem cast irons. **HABCO CI 885** can be used as a butter pass before using machinable cast iron electrodes or as a wear resistant layer for build-up areas exposed to abrasion.

INSTRUCTIONS

Grind or gouge out crack using **HABCO MX 222**. Clean and prepare weld zone in accordance with standard welding practice. Do not preheat. Use lowest effective amperage while maintaining a short arc length. Deposit short beads and skip weld to reduce heat input. Allow casting to cool slowly.

Tensile Strength: up to 60,000 Psi (42 kg/mm²)

Elongation: up to 33%

Current: AC or DC +

Amperage:	35-80	75-110	100-150	110-160
Diameters: (in)	3/32	1/8	5/32	3/16
(mm)	2.5	3.25	4.0	5.0