

## **HABCO CI 884**

**GENERAL PURPOSE, OXY-ACETYLENE TORCH  
WELDING ALLOY FOR CAST IRON**

### **FEATURES**

**HABCO CI 884** was developed to repair a wide variety of cast irons, including joining applications that require an excellent color match and compatible properties to the base metal. **HABCO CI 884** is especially good for filling porous areas, build-ups and joining many grades of cast iron. All deposits are dense and machinable.

### **APPLICATIONS**

**HABCO CI 884** is ideal for use on cast housings, machine frames, and build-up of worn or missing areas. **HABCO CI 884** is perfect for salvaging castings which are scrapped for machining or casting flaws.

### **INSTRUCTIONS**

Clean and bevel joint. Heat uniformly and keep torch in motion. Apply **HABCO FX 800** FLUX on rod and work piece. Continue heating to liquify. Apply **HABCO CI 884** one drop at a time, making certain each drop wets out. Do not overheat base metal, and allow part to cool slowly.

**Tensile Strength: up to 40,000 Psi (28 kg/mm<sup>2</sup>)**

**Hardness: up to 190 HB**

**Working Temperature: 1600°F (871°C)**

#### **Diameters:**

(in) 1/4  
(mm) 6.0

**FLUX: HABCO FX 800**