

HABCO CX 886S

A SUPER STRENGTH ALLOY FOR REPAIRS ON CONTAMINATED CAST IRONS

FEATURES

HABCO CX 886S produces high strength, crack resistant and porosity free welds on difficult to weld cast irons. Ideal for use on old, oil-soaked dirty base metals. Arc is smooth and stable even on AC. Weld puddle fluidity is easily controlled in all positions and wetting action, even on dirty castings, is exceptional. Deposits are machinable.

APPLICATIONS

This exceptional electrode can be used on gray, malleable and ductile iron castings. It will produce successful repairs on engine blocks, manifolds, gear housings, transmission cases, sewer pipes 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 in accordance with standard welding practice. Vee-out cracks using **HABCO MX 222**. Use skip weld technique on complicated castings. Limit bead length to 1 – 1 1/2" to minimize heat input. Maintain a maximum inter-pass temperature of 200°F (93°C). Chip slag between passes and peen weld with ball end of a ball peen hammer to stress relief.

Tensile Strength: 75,000 psi (24kg/mm²)

Brinell Hardness: 210

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

• Available in (GTAW) TIG and (GMAW) MIG form