

HABCO CX 887S

**PREMIUM HIGH NICKEL, NON-CONDUCTIVE FLUX COATED
CAST IRON ELECTRODE, MAXIMUM MACHINABILITY**

FEATURES

HABCO CX 887S has a very special coating, which prevents side arcing and produces a pulsed arc for low temperature welding of all cast irons. Weld deposits are dense, porosity free and fully machinable. **HABCO CX 887S is the coolest running non-conductive cast iron electrode manufactured today.**

APPLICATIONS

For low temperature, repairs on all grades of cast iron where an easily machined deposit is required. Ideal for intricate or thin wall gray iron castings. Excellent for repairs on cast iron gears and pulleys, machine tools, engine blocks and pump housings. This is also an exceptional electrode for joining dissimilar metals such as monel, copper, stainless, nickel and steel or combinations of these.

INSTRUCTIONS

Clean and prepare weld zone in accordance with standard welding practice. Vee out cracks with **HABCO MX 222** gouging rod. Maintain a short to medium arc using the largest diameter and lowest amperage setting to produce the softest weld deposit. Use short stringer beads or skip welding technique to minimize local heat input. Peen to reduce stress using the ball end of a ball peen hammer. Allow to cool slowly.

Tensile Strength: 50,000 Psi (35 kg/mm²)

Elongation: approx. 30%

Brinell Hardness: 160

Colour Match: Similar to cast iron

Current: AC or DC -

Amperage:	30-70	55-110	75-135	100-175
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