

# HABCO CX 888 (S)

## PREMIUM ELECTRODE FOR WELDING OF ALL CAST IRON – HIGH STRENGTH ALLOY

### FEATURES

A true universal high strength cast iron electrode **specially developed for maintenance and repair welding of all commonly known types of cast iron**. The special core wire features a high current carrying capacity, and the flux coating is designed to transfer impurities from the base metal into the slag. Due to its relatively high nickel content, deposits are easily machined. Excellent out of position welding.

### APPLICATIONS

For fabrication and difficult repair of all gray and alloyed cast irons. Recommended for welding cylinder heads, machine bases, gear housings, cams, levers, filling holes, repairing teeth of cast gears and building up or replacing missing sections. Commonly used to weld ductile iron, “Ni-Resist” and “Meehanite” castings to themselves or to steel. Also suitable for joining nickel alloys to gray cast iron, malleable cast iron and cast steel.

### INSTRUCTIONS

Clean weld area if possible. Remove surface skin and all sharp edges. Bevel joining area to form a “U” groove using **HABCO MX 222**. A bead hole must be welded at right angles to each end of all cracks to prevent spreading during welding. Use low amperages and maintain a short arc. Short stringer beads or narrow weave beads should be used to prevent excessive heat build-up. When breaking the arc always fill the crater and drag rod back over the weld deposit. Peening while still hot will help reduce stresses. When re-striking the arc, start on previously deposited weld metal, not on the base material. Allow part to cool slowly.

**Tensile Strength: 80,000 Psi (56 kg/mm<sup>2</sup>)**

**Elongation: approx. 20%:**

**Brinell Hardness: 200**

**Current: AC or DC -**

<b>Amperage:</b>	<b>35-80</b>	<b>65-120</b>	<b>75-140</b>	<b>100-170</b>
<b>Diameters: (in)</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>	<b>3/16</b>
<b>(mm)</b>	<b>2.5</b>	<b>3.25</b>	<b>4.0</b>	<b>5.0</b>