HH 4 CAST IRON

BARE ROD FOR GAS WELDING

General Characteristics

HH 4 cast iron welding rods work best when used with a cast iron brazing flux. Deposits are easily machined and color match is excellent to grey cast iron. HH 4 cast iron will rust like cast iron, and therefore, machined parts are not noticed as would the deposit of a nickel electrode.

Procedure

Remove rust, dirt and grease using a commercial degreaser, and then bevel sections to form a 75^0 vee. Always use a slightly carburizing flame to prevent prosity due to oxidation of carbon. Preheat part to 800^0 F (430^0) before starting to weld. When using bare rods, heat one end of the rod and dip into the flux, and transfer to the weld area. Melt off a small amount of rod, continue heating until the deposit flows, and then continue to add filler metal a drop at a time making sure that each deposit is fusing to the base metal. Use sufficient flux for good cleaning and protection of the base metal. After welding, allow part to cool slowly to prevent hardening or cracking.

Application

Torch welding for maintenance and production of heavy and light castings. Commonly used on parts where color match is critical such as filling of surface defects and building up worn or missing sections. Also used to repair machine bases, manifolds, engine blocks, cylinder heads and gear housings.

Tensile Strength	**40,000 PSI**
Yield Strength	**34,000 PSI**
Elongation	**30%**
Hardness (HB) Brinell	**Approx. 200**
Working Temperature	**1600^0 F**

Diameter	**(Inch)**	**3/16**	**1/4**	**5/16**