

CARVER 9755

FEATURES

CARVER 9755 is for the repair and joining of heavy sections of cast iron. Weld deposits are non-machinable. Designed specifically for on-the-job repairs of cast iron, which eliminates the necessity of dismantling equipment. While pre-heating is recommended, the electrode may be used without pre-heating or post-heating in many instances.

APPLICATIONS

Welding or surfacing of Cast Iron. Joining of cast iron to steel. Economical electrode particularly for massive parts and large castings. E.g. repair of foundry defects, damaged or cracked castings. Can be used on rusty, corroded and oil soaked parts. Good bonding properties on difficult to weld cast iron. For obtaining better machinability, deposit final pass with CARVER 9700 Or 9750.

PROCEDURE

Clean welding zone. Select lowest amperage possible. Use short arc and guide electrode steeply since it gives spray transfer, helpful for sealing pores in Cast iron. After each bead peen deposit.

TYPICAL DATA

Alloy Type	:	Fe, Ni Alloy
Tensile Strength	:	580 N/mm ²
Machinability	:	Non-Machinable

RECOMMENDED CURRENT RANGE

SIZE (mm)	3.15	4.00	5.00
AMPS	60-110	100-140	140-170

**ECONOMICAL NON-MACHINABLE
FERROUS ELECTRODE FOR CAST IRON WELDING**