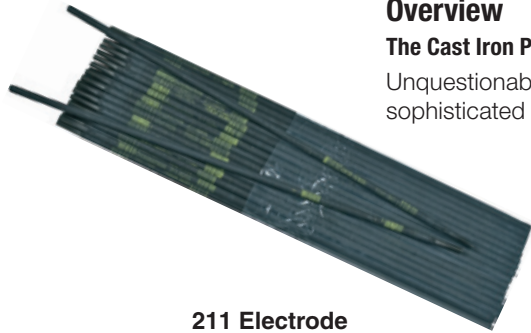


## Overview

### The Cast Iron Problem Solver

Unquestionably the final answer to the most difficult cast iron repair welding. This highly sophisticated alloy allows repairs that were previously impossible.



211 Electrode



211M-FC MIG Wire



211T TIG Wire



## Features/Benefits

- High-tensile welds in every type of cast iron, including grey and Meehanite®. Also produces excellent steel-to-cast iron welds
- 211 is fully machinable and has a high elongation factor which positively prevents cracking
- Pass-over-pass welding without slag removal between passes
- All-position welding can be done with 211 without dismantling equipment parts

## Applications

- Gear teeth
- Sprockets
- Pump housings
- Bearing housings
- Turbines
- Pump impellers
- Cast iron to steel
- Cylinder blocks and heads
- Transmission cases
- Hydraulic press rams

## Method of Application

AC or DC reverse polarity

## Identification

Printed black electrode; TIG flagged one end

## Directions for Use

Use AC or DC reverse polarity. Generally, where a narrow, thin bead is desired, a straight polarity application is suggested.

## Technical Specifications

Tensile Strength (Electrode): 84,000 PSI (579 MPa)  
Hardness: 185 to 240 BHN

