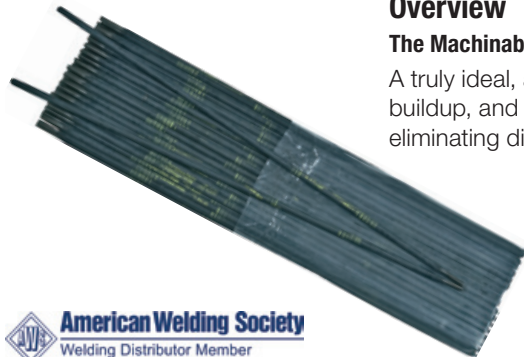


# Technical Data Sheet

## Cronacast™ 222 Electrode



Cronatron™  
A LAWSON BRAND



### Overview

#### The Machinable Cast Iron Alloy

A truly ideal, all-position cast iron electrode for “cold” welding repairs of cracks and breaks, buildup, and cladding or replacing broken and missing sections. Excellent for overhead work, eliminating dismantling.



### Features/Benefits

- Excellent color match
- Easily machinable, dense, crack-free welds
- Vertical, overhead and hard-to-get-at places repaired easily without disassembling
- No preheating required
- Does not side-arc

### Applications

- Cast iron blocks
- Machine bases
- Tanks and vats
- Heads and pans
- Castings and housings

### Method of Application

AC or DC straight or reverse polarity

### Identification

Printed black electrode

### Directions for Use

Remove grease, scale and other impurities from weld area. Bevel cracks or breaks (70° to 90° “Vee”). Cronacut Eagle™ 1100 is the fastest and easiest method to prepare section for weld repairing. Use a short to medium arc at the lowest possible amperage for best results. Employ weaving technique or stringer beads. Peen to relieve stress. Remove slag between passes. Slow cooling at room temperature recommended.

### Technical Specifications

Tensile Strength: 65,000 PSI (448 MPa)  
Hardness: 170 to 200 BHN

