

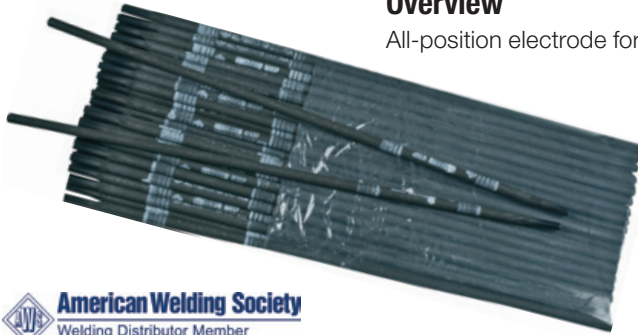
Technical Data Sheet

889SP AC-DC Electrode



Overview

All-position electrode for cast iron repair, and joining and welding cast iron to steel.



Features/Benefits

- Unique alloy composition and construction help provide crack-resistant, porosity-free welds on cast iron without preheating
- Bi-metal core wire construction allows 889SP to run on a wide amperage range without overheating
- No overheating means a soft, smooth arc that will not snuff out or stick during operations
- Controlled arc action reduces the size of the heat-affected area.
- Welds through oil, grease and other contaminants
- Easy-to-control electrode produces smooth, dense, non-porous deposits that are easily machinable
- Weld spatter is minimal and slag deposits are virtually self-releasing
- For best results, preheat large cross-sections to room temperature

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 straight or reverse polarity

Identification

Printed black electrode

Directions for Use

Use AC or DC polarity. DC reverse for deeper penetration and DC straight for thin sections. Preheat cast iron to 400°F to 600°F (205°C to 315°C) for best results and allow to slow cool.

Technical Specifications

Tensile Strength: 84,000 PSI (579 MPa)
 Yield Strength: 63,000 PSI (434 MPa)
 Hardness: 180 BHN to 222 BHN, as welded

