



WELDCOTE 2800

Nickel-Free Electrode for Cast Iron (AC-DC), Non-Machinable

DESCRIPTION: **WELDCOTE 2800** is a nickel free electrode for the repair of cast iron. It is used for joining cast iron to steel and is a great choice for rusty, oily, greasy or chemically soaked or burned out castings. This electrode is a perfect color match to cast iron, but it will rust. It can be used in flat, vertical up, horizontal, vertical down and overhead positions.

PROCEDURE: Use either AC or DC reverse polarity. Clean weld area. For grooving or veeing out cracks, grind or use **WELDCOTE CHAMFER ARC**. Drill small holes at the end of cracks to prevent spread of cracking. Preheat of 400° F will provide best results. Skip or back-step weld on long cracks. Short weld deposits of 1 ½" are recommended. Peen each bead while still hot to relieve stresses. Maintain a close arc. Allow casting to cool slowly.

FEATURES: Tensile strength: up to 62,000 psi
Yield strength: up to 50,000 psi
Elongation: 20%
Hardness: Brinell 380 Rockwell C39

PACKAGING: **WELDCOTE 2800** is available in 1/8 diameter, packed in ten pound tubes, 40 lbs per master carton. **Amperage** 70-125 amps