



TIG-Tectic 224

High strength nickel filler alloy rod for TIG welding cast iron.

Description:

TIG-Tectic 224 is a high nickel-depositing TIG rod designed to provide strong, ductile, machinable deposits on all cast irons, with good match in coefficient of expansion and colour. TIG 224 offers the greater degree of Machinability.

Mechanical Properties:

Tensile Strength: 50,000Psi

Shielding Gas:

Recommended gas: 100% argon

Applications:

- Motor blocks
- Machine Bases
- Farm Equipment
- Gears & Gear Cases
- Pulleys
- Pump Housings & Impellers
- Compressors
- Foundry Defects

TIG-Tectic 224 is the ideal filler metal for repair of grey cast iron sections and for joining cast irons to steels. Excellent for fabricating, cladding, building up missing sections, filling porosity and repairing breaks and cracks in castings. Well suited for machinable repairs.

Procedure for use:

Preparation:

The surfaces of the joint preparation and the adjoining arrears have to be clean, i.e.: no oxidation, grease, paint, etc.

Welding:

Polarity = (-) negative polarity

Angle between torch and work piece for a flat joint: 70-80° Angle between rod & work piece 15-30°

To minimise heat build up use skip welding. Back whip craters and peen hot weld beads, to relieve stresses. Allow the casting to slowly return to room temperature.

Welding Positions:

PA, PB, PC, PE, PF, PD according to ISO 6946

Recommended welding current:

Electrode Diameter mm	Welding Current DC
1.6mm	0-150
2.4mm	110-180

Machining: The TIG deposit can be machined with standard cutting tools & can also be cut by the plasma cutting process.

Rod Diameter: 2.4mm

DIGITALWELD

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