XYRON 224

High Nickel electrode for machinable welding grey cast irons

Description:
Xyron 224 is a graphite coated electrode that provides a nickel alloy deposit used for joining, coating, building up missing sections, filling holes & porosity and repairing breaks & cracks. Exceptional for parts that are oily such as motor blocks, motor housings etc.

Features:
Excellent machinability:
Weld deposits are fully machinable.
Exceptional versatility:
Xyron 224 is a very versatile alloy for joining, coating, building up and repair of cracks and other defects in grey and alloy cast irons. It can be easily used in all positions.
User friendly:
Xyron 224 has a specially formulated flux coating which makes it very easy to use.
Base Metals:
Xyron 224 can be used for joining, coating and building-up cast irons as well as for joining cast iron to steel.
Low amperage welding current, low dilution with the base metal.

Technical data:
Tensile Strength: 370Mpa (50,000 Psi)

Application Method:
Metallic arc welding. AC/DC straight polarity.

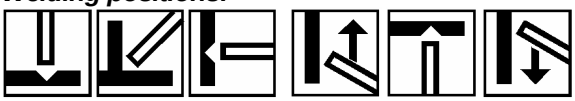
Typical Applications:

Bell Housings	Machine Bases
Gear Boxes	Gears
Motor Blocks	Flanges
Cylinder Heads	Pipelines
Pump Housings	Sprockets
Transmission Housings	Foundry Defects

Application Procedure:
Preparation:
Completely clean weld area. Bevel breaks, cracks and stress raisers (eg sharp corners, edges) to a 75-90^{o} vee. Use ExoTrode for optimum results.
Preheating:
In most cases preheat may not be required. However, for maximum machinability the work piece may be preheated to about 315^{o}C. Maintaining proper preheat and interpass temperatures will also facilitate welding of complicated castings.
Welding:
Use AC or DC straight polarity. Strike initial arc on clean scrap steel and carry over to weld area. Use short to medium arc at the lowest amperage feasible. Deposit stringer beads and restrict weaving, if used, to 2 x electrode diameter. To minimise heat build up use skip welding. Back whip craters and peen hot weld beads, to relieve stresses. Remove slag between deposits. Allow the casting to slowly return to room temperature.
Recommended Amperages:

Size:	2.4mm	3.2mm	4.0mm
Amperage:	50-80	70-110	90-130

Welding positions:



Standard Diameters:
2.5mm, 3.2mm, 4.0mm
Diameters available ex stock vary according to demand.

Packaging Storage and Packaging:
Safely stack and store electrodes in a dry location to avoid humidity pick up or coating damage. Should electrodes become damp, the following re-drying conditions before use are recommended: 350°C / 2 hr.

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