Xuper 22*33N

Superior crack resistance, low heat input electrode for cast irons, AC/DC

Description :
Xuper 22*33N is a low amperage flux coated electrode for a wide range of cast iron (and cast iron-to-steel) applications. 22*33N offers highly crack resistant and machinable weld deposits. It has superior weldability and wash characteristics. As a result, the weld beads are flat, even and finely rippled. At rated amperages, electrode overheating (which causes flux coating to break-off) is practically non-existent. The entire length of 22*33N can be used productively for making sound welds. The smooth, stable arc has great strike/restrike characteristics and there is hardly any spatter or fuming. 22*33N is an ideal solution for a variety of cast iron repairs under demanding conditions viz: joints under restraint, massive sections, dissimilar thicknesses, circumferential pipe welds to flanges, etc. 22*33N is strongly recommended for welds which must be leak proof and have hydrostatic integrity.
Tip Colour: Brown

Features and Benefits :
Tough, strong welds
Superior weldability in all positions
Easy machinability
Minimum heat input
No overheating or flux breakdown
Superior arc control
Smooth, stable arc with easier strike/restrike
Minimum fuming or spatter
Versatile

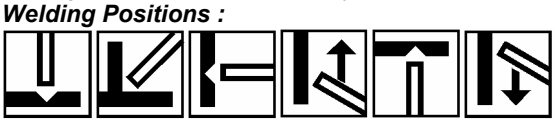
Technical Data :

Tensile Strength :	400MPa
Hardness (typical):	90Rb
Elongation (typical):	15%

Typical Applications :
Repairs to machine bases and frames.
Pump and differential housings.
Oil sumps, massive parts in cast iron.
Thick-to-thin cast iron section joining.
Cast iron die build-up.
For joining and repairs on SG iron.

Base Metals :
22*33N can be used for most cast irons, including SG, Meehanite, malleable, alloy and grey - and for joining those cast irons to steel.

Procedure :
Preparation :
Clean weld area, removing any contaminants such as oil/grease, moisture, dirt, inclusions, etc. Vee out cracks and any other stress raisers, using Xuper ExoTrode.
Preheating :
Although preheat is not required for some applications, best results are often obtained by preheating to approximately 260^{o}C and maintaining this temperature until completion of welding.
Welding :
Use AC or DC reverse polarity and direct the arc onto deposited weld metal. Light peening of hot weld beads is recommended for relieving stresses. Remove slag between passes. For complicated assemblies, use a skip welding technique. On completion of welding, cover the casting and allow it to cool slowly.
Welding Positions :



Weld Parameters : (AC/DC +ve)
3.2mm 90 - 120 amps
4.0mm 120 - 160 amps
Diameters available ex-stock vary according to demand.

Packaging :
22*33N is packaged and shipped in Dry-Pak containers to keep every electrode clean and dry.

DIGITALWELD
J.D.M Holdings Ltd
Unit D/17 Hobill Avenue, Wiri, Manukau, 2104. P.O Box 97622 Manukau City, Manukau 2241, New Zealand
Ph: +64 (09) 263 7099 Fax: +64 (09) 263 5062 Email: sales@digitalweld.co.nz Website: www.digitalweld.co.nz