



## Xuper 2240

Low heat input electrode for Cast Irons,  
Nodular deposits providing excellent crack resistance

### Description :

Xuper 2240 is a low heat input electrode for cast irons. The peripheric 'arc within arc' of 2240 results in superior ionization, excellent penetration of contaminated surfaces and controlled spray transfer during welding. The unique nodularized microstructure of 2240 weld deposits, ensure strong, ductile welds with exceptional crack resistance. Low heat input results in minimum penetration and therefore, a smaller HAZ. The graphite in the weld metal exists in nodular form, which increases weld metal ductility and crack resistance substantially.

2240 is excellent not only for welding all types of cast iron, but also cast iron-to-steel. It can be used for joining, as well as for overlaying, build ups and repairing defects. 2240 is suitable for all types of sections - thick, medium and thin - and for joining thick-to-thin sections.

2240 can reduce your labour costs as it offers:

- Minimum preparation
- Rapid deposition
- Easy clean up
- All positional capability (for in-situ welding)
- Minimum weld spatter
- User friendliness

2240 deposits are readily machineable. 2240 is very easy to use. The alloy transfers in a smooth spray type action and has excellent wash and fluidity. The arc is stable, with no undercutting and excessive spatter and fuming is minimal.

Moreover, the weld deposits have smooth appearance and have a good colour match to cast iron.

**Tip colour:** Silver

### Features :

- High Crack Resistance
- Strong
- Versatile
- Economical
- Machineable
- Reduced Welding Time
- User Friendly

### Technical Data :

Tensile Strength: 380-415mpa

### Typical Applications :

Air cylinders	Jacketed castings
Bell housings	Manifolds
Cams	Motor housings
Cast iron dies	Pipelines
Clutch housings	Presses
Compressor castings	Pressure chambers
Connecting arms	Pulleys
Cranes	Pump housings
Cylinder heads	Pump impellers
Differential housings	Rolls
Frames	Sprockets
Foundry defects	Suction pumps
Gear box housings	Transmission housings
Gear teeth	Valves
Hoist drums	Water jackets

### Application Procedure :

#### Preparation :

Clean weld area. Vee out all cracks and any potential stress raisers using ExoTrode.

#### Welding :

Maintain short-to-medium arc, directing arc onto deposited weld metal. Use skip welding on complex castings or cylindrical work pieces. Fill weld craters. Remove slag between passes. Light peening of hot weld beads can help relieve stresses. Allow the casting to slowly cool down.

#### Welding positions :



#### Recommended Amperages :

Size: 2.5mm 3.2mm 4mm  
Amps: 60-90 85-115 110-140

#### Electrode Diameters :

2.5mm, 3.2mm and 4.0mm  
(Diameters available ex stock vary according to demand.)

#### Packaging :

2240 is packaged and shipped in Dry-Pak containers to keep every electrode clean and dry.

# DIGITALWELD

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