



ARCWEL 190-SMAW

For joining and rebuilding cast iron

- ◆ **High strength nickel base alloy for welding and overlaying of different Cast irons** such as grey cast iron nodular cast iron and for joining cast iron to steel. Electrode has exceptional good mechanical properties. Can also be used as a bonding layer on dirty or oily cast iron.
- ◆ Used for weld repairs of pump housing, machine bases, automotive press & ingot molds, deep drawing dies, engine blocks, flanges, foundry defects ,cylinder heads, couplings , cast iron mill rolls etc.
- For joining cast iron to steel
- Good machinability, bimetal core wire preventing overheating
- Excellent penetration (bonding) on even on contaminated surfaces
- ◆ Weld deposit has good color match on cast iron and is therefore ideal for repairing foundry defects.

Mechanical Properties (Typical)

UTS Rm [MPa]	YS Rp 0.2 [MPa]	Elong. A [%]	Hardness HB
540	310	16	190 - 220

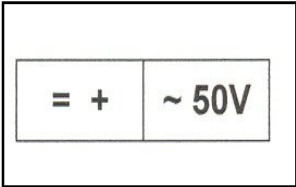
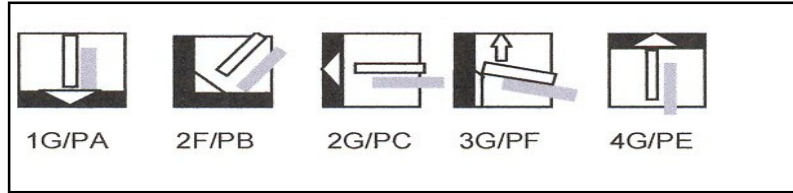


Sizes /Packages (SMA) Stickelectrodes SMAW

Ø [mm]	length [mm]	current range [A]	pack [kgs.]	weight / ctn. [kgs.]
3,2	350	110 - 120	5	20
4,0	350	140- 160	5	20

Welding positions / Current AC/DC

ROLLER REPAIR WITH 190 SMAW



Note: this alloy is also available as flux cored wire for MIG (FCAW) welding and as GTAW (TIG) welding rod : Data sheets are available on request

Disclaimer/ Warranty.
 The information and data presented herein are typical or average values. Application suggested are made solely for the purpose of illustration to enable the reader to make his own valuation and are not intended as warranties. Arcwel reserves the right to alter specification without further notice.
 Health & Safety : Observe safety regulations (fumes) MSDS available on request
www.arcwel.com E-mail: info@arcwel.com