



HH 2 CAST IRON WIRE

MIG WIRE AND TIG WIRE

General Characteristics

HH 2 Cast Iron MIG and TIG is a solid bare wire whose properties are of a unique nickel-iron-manganese metallurgical structure. It is designed for use on ductile, malleable and grey cast irons in all positions and at a high deposition rates of up to 18 lbs. per hour. The wire may be used with the TIG process or with the MIG process utilizing the spray, pulsed arc, or short-arc methods. DC current should be used in all applications with Straight Polarity for TIG applications while Reverse Polarity with Constant Voltage is required for MIG applications. Argon shielding gas should be used with TIG applications, and Argon/CO₂ (75/25) should be used for MIG applications. This product produces high strength and ductile welds, while maintaining machinability and color-match.

Procedure.

Remove contaminants from the welding zone. Pre-heat is normally not necessary, but may be helpful on large, heavy sections, or fully restrained joints. Use the following welding parameters for the MIG wire.

GAS	WIRE FEED	VOLTAGE	CURRENT	STICK OUT	TRAVEL SPEED
75/25	300	24	130	1/2	15
75/25	400	25	160	1/2	15
75/25	500	26	180	1/2	15
Argon*	500	28	220	1/2	15

*denotes Spray Transfer

Application

For the repair of cast iron to themselves and other materials, and for repairing worn or broken parts, and for salvaging defective castings where high strength and ductility are required.

Tensile Strength	100,000 PSI
Yield Strength	65,000 PSI
Elongation	35%
Impact Strength (ft-lb.)	8
Hardness (HB) Brinell	Approx. 200

Available in TIG wire sizes 1/16 and 3/32 x 36 or in MIG wire in .035 and .045 x 5 lb. or 25 lb. spools