



HH 3 CAST IRON WIRE

MIG WIRE AND TIG WIRE

General Characteristics

HH 3 Cast Iron MIG and TIG is a solid bare wire whose properties are a full nickel 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 ductile welds, while maintaining machinability.

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.

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|-----------------------|-------------|
| Tensile Strength | 71,000 PSI |
| Yield Strength | 49,000 PSI |
| Elongation | 12% |
| Hardness (HB) Brinell | Approx. 160 |

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