

SUNALLOY 711

Non-machinable electrode for welding cast iron



DESCRIPTION

SUNALLOY 711 specifically designed for the hot repair of ingot moulds. Also for sealing dirty and contaminated cast-iron.

ALLOY BASIS

Fe, C, Si

PROPERTIES

Electrode with good bonding properties even on difficult to weld cast iron. Close colour match between deposit and base material. Non-machinable. Shape by grinding.

APPLICATIONS

Welding and surfacing of cast iron. Joining of cast iron to steel. Economical electrode particularly indicated for massive parts and large castings, e.g. repair of foundry defects, damaged or cracked castings. Can be successfully used on rusty, corroded and oil soaked parts. For obtaining better machinability, deposit final pass with SUNALLOY-511 or SUNALLOY-911

PROCEDURE

Clean the welding zone. Select the lowest amperage possible. Use short arc and guide the electrode steeply since the electrode gives a spray transfer, helpful for sealing pores in cast iron. After each bead peen the deposit. If the surface of the welded joint must be machinable, weld the cover passes with either SUNALLOY -511 or SUNALLOY -911.

TECHNICAL DATA

UTS of joint : up to 60 kgf/mm² (Approx.)

WELDING PARAMETERS

Size (diameter)/length (mm) :	2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (amps) :	40 - 70	60 - 120	100 - 150	130 - 180
Current :	AC/DC (+)			