

## TECHNICAL DATA SHEET

 **Starweld 589**

**AC / DC +**

### CAST IRON

#### Description :

Unique steel coated nickel core electrode for easy welding of cast iron to steel, as well as unknown and European cast irons and those with dirty and/or oily surfaces.

#### Characteristics :

- **Maximum resistance to cracking**
- Cold welding in all positions
- Machinable deposits
- Easy slag removal
- Very low amperage

#### Mechanical properties :

- Polarity AC / DC +
- Tensile strength : 70 000 psi (485 MPa)
- Hardness : 190 BH

For best results, use a short arc and hammer the beads to relieve stress. For preparation of dirty cast irons, use **Starweld 512**. Interpass temperature and cooling must be controlled to ensure good deposit quality.

+ <b>Diameter</b>	2.5 mm	3.2 mm	4.0 mm
+ <b>Amperage</b>	75 A	110 A	140 A

#### Applications :

Assembly and repair of all types of cast irons, thick sections and dissimilar cast iron/steel assemblies, machinery bases, presses, gear boxes, compressors, cast iron molds, gear teeth, etc.

**1 800 361 9097**

 **Starweld**