

 **Starweld 589 Cu**

AC / DC +

CAST IRON

Description :

Specially coated electrode with copper-clad ferro-nickel core for cold welding and building up of gray cast iron, malleable cast iron, spheroidal cast iron, etc. Excellent for steel to cast iron assemblies.

Characteristics :

- **Good anchorage**
- Machinable and crack-resistant deposits
- Dense and non-porous deposits
- Excellent weldability in all positions and on AC/DC power supply
- Very high melting rate at low amperage

Mechanical properties :

- Polarity AC / DC +
- Tensile strength : 75 000 psi (517 MPa)
- Hardness : 200 BH

Keep heat input between passes as low as possible (maximum temperature 70°C) to minimize the risk of cracking the base metal - lay short beads of approx. 3 cm and hammer immediately before making a new bead - weld on clean, grease-free surfaces (grind the joint beforehand).

Procedure :

Remove any trace of oil, grease and/or dirt from the surface. Remove cracks with **Starweld 512B** electrode. Maintain a short arc and peen while still hot between each pass to stress relieve. Cool slowly.

+ Diameter	2.5 mm	3.2 mm
+ Amperage	70 A	100 A

Applications :

Casting defects, repair of engine blocks, machine frames, tools, gearboxes, reduction gears, pump bodies, castings, valve bodies, etc.

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