

## TECHNICAL DATA SHEET

 **Starweld 599**

**AC / DC +**

### CAST IRON

#### Description :

Specially-coated electrode with very high nickel content and non-conductive flux coating recommended for cold welding of all types of cast irons, even when dirty and/or oily, where watertightness and/or 100% machinability are required.

#### Characteristics :

- 100% machinability
- Ideal for thin cast irons repairs
- Low amperage
- All-positions electrode

#### Mechanical properties :

- Tensile strength : 60 000 psi (414 MPa)
- Hardness : 160 BH

#### Procedure :

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

- + **Diameter**
- + **Amperage**

2.5 mm  
75 A

3.2 mm  
110 A

4.0 mm  
140 A

#### Applications :

Recommended for cold welding of all types of cast irons (grey, nodular, malleable, etc.) of thin to average thickness, dissimilar assemblies (cast iron/steel), engine blocks, cylinder heads, sleeves, machining errors, gear boxes, pump casing, etc.

**Also available in TIG : Starweld T599 and in MIG : Starweld 2599M**

**1 800 361 9097**

 **Starweld**