



# EAGLE 180

*A High Strength Alloy For Repairs On Cast Iron*

## APPLICATIONS

This electrode can be used to weld gray, ductile and nodular cast iron. Excellent for build-up or joining on repairs to engine blocks, housings, sprockets, transmission housings, gear teeth and machine bases. Deposits are fully machinable.

## PROCEDURE

Use AC or DC Reverse [+] Polarity. Prepare and clean weld area. Groove out cracks using the **EAGLE 188**.

Use lowest effective amperage while maintaining a short to medium arc length. Short weld deposits are recommended (1" – 1½") using the skip weld method to reduce heat input. Peening while hot will help to reduce stresses. Allow casting to cool slowly.

## GENERAL CHARACTERISTICS

The **EAGLE 180** is a high strength special alloyed core electrode that will produce porosity free welds on all types of cast iron.

## TECHNICAL DATA

Tip Colour:	Dark Green
Hardness: (BH)	200
Typical Tensile Strength	up to 70,000 psi (483 N/mm <sup>2</sup> )
Typical Yield Strength	up to 50,000 psi (345 N/mm <sup>2</sup> )
Elongation	approx. 18%
Typical Hardness	87-90 HRB
Polarity/Current	AC or DC reverse (electrode+)

## WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes:	Inches	3/32	1/8	5/32
	mm	2.50	3.25	4.00
Amperage:	35 - 70	70 - 110	120 - 130	



SINCE 1990

≡ HIGH QUALITY WELDING PRODUCTS ≡

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