

Technical Data Sheet

235 Electrode



Cronatron™
A LAWSON BRAND



Overview

Specifically formulated for safe, secure welds on burned, rusty, corroded or otherwise contaminated cast iron parts not requiring machining.

Features/Benefits

- All-position weld repairs on manifolds, furnace grates and doors
- Deposits a porous-free weld through rusty or burned cast iron section
- Ideal color match and will rust at a matching rate to parent cast iron
- Repairs foundry defects and cracked or broken sections
- Will not side-arc

Applications

- Cylinder heads
- Manifolds
- Machine bases
- Structural castings
- Furnace grates, doors or housings
- Pulleys, frames and supports

Method of Application

AC or DC reverse polarity

Identification

Printed gray electrode

Directions for Use

Use AC or DC reverse polarity. Maintain a medium to short arc as needed using the lowest amperage necessary. Preheating to 350°F to 400°F (175°C to 205°C) reduces stress. To prevent cracks from propagating, drill a small hole 1/8" to 3/16" (3.2mm to 4.7mm) at each end, then groove out the crack with Cronacut Eagle™ 1100.

Technical Specifications

Tensile Strength: 60,000 PSI (414 MPa)

