Premium Cast Iron Electrodes and Wires

All-position welding for any type of weldable cast iron repair and cast iron to steel.

Superior Advantages

- High strength welds
- Fully machinable
- Pass-over-pass welding to save time
- All-position welding may eliminate the need to dismantle equipment to perform repairs

Applications

- Pump and bearing housings
- Cylinder blocks and heads
- Machine bases
- Manifolds and exhaust systems

Certanium® Alloys

For all cast irons – even steel to cast iron – without preheating

889 SP Electrode

Tensile Strength: Up to 84,000 PSI
Hardness: 180 – 222 BHN
Polarity: AC or DC Straight or Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	60 – 100	**P12001A**	5
3/32	60 – 100	**P12001**	10
1/8	85 – 120	**P12003A**	5
1/8	85 – 120	**P12003**	10
5/32	90 – 140	**P12006A**	5
5/32	90 – 140	**P12006**	10
3/16	120 – 170	**P12009A**	5
3/16	120 – 170	**P12009**	10

89T TIG Wire

Tensile Strength: 73,300 PSI
Polarity: DC Straight
Gas: 100% Ar

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/16 x 36	**P14160**	3
3/32 x 36	**P14170**	3
1/8 x 36	**P14180**	3

Cronatron Alloys

270 Electrode

Tensile Strength: Up to 84,000 PSI
Elongation: 12 – 15%
Hardness: Rb 90
Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	65 – 90	**CW2070**	5
1/8	70 – 130	**CW2071**	5
5/32	100 – 175	**CW2072**	5
3/16	200 – 275	**CW2073**	5

Cronatron Alloys

211 Electrode

Tensile Strength: Up to 84,000 PSI
Hardness: 185 – 240 BHN
Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	55 – 95	**CW1035**	5
1/8	75 – 110	**CW1034**	5
5/32	120 – 150	**CW1033**	5
3/16	140 – 175	**CW1032**	5

211M-FC MIG Wire

Tensile Strength: 74,000 PSI
Elongation: 12%
Hardness: Rb 87
Gas: 98% Ar, 2% O_2

Dia. (Inches)	Part No.	Pkg. Qty. (Lbs.)
.035	**CW2065**	10
.035	**CW2066**	33
.045	**CW2057**	10
.045	**CW2058**	33
1/16	**CW2059**	33

211T TIG Wire

Tensile Strength: Up to 60,000 PSI
Hardness: 185 – 240 BHN
Polarity: DC Straight
Gas: 100% Ar

Dia. x Length (Inches)	Part No.	Pkg. Qty. (Lbs.)
1/16 x 36	**CW1901**	2
3/32 x 36	**CW1902**	2
1/8 x 36	**CW1903**	2

Specialty Alloys

Cronacast 222 Electrode

Easily machinable cast iron repairs

The high nickel content in 222 provides for easy machinability.

Tensile Strength: 65,000 PSI
Hardness: 170 – 200 BHN
Polarity: AC or DC Straight or Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
3/32	40 – 75	**CW1861**	5
1/8	80 – 110	**CW1036**	5
5/32	100 – 140	**CW1835**	5

235 Electrode

Iron-adding

235 is specifically formulated for welding on burned, rusty, corroded or otherwise contaminated cast iron parts not requiring machining.

Tensile Strength: 60,000 PSI
Polarity: AC or DC Reverse

Dia. (Inches)	Amps	Part No.	Pkg. Qty. (Lbs.)
1/8	80 – 120	**CW1037**	5