

Addifix 860

**THE REVOLUTIONARY HIGH NICKEL
ELECTRODE FOR WELDING CLEAN CAST
IRON (AC/DC+)**

Advanced. smooth running high
performance electrode

Tensile Strength:	50,000-60,000 PSI
Elongation:	35-45 percent
Hardness:	160 brinell
Diameters:	3/32 1/8 5/32
Amperages:	90 105 115

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- **Welds a variety of cast irons.**
 - **Machinable.**
 - **Produces high strength welds.**
 - **General purpose electrode for use on relatively clean, oil free cast irons.**
 - **Welds cast iron to steel and cast iron to stainless steel.**
 - **No undercut.**
 - **Low smoke and spatter.**
 - **Easy slag removal.**
 - **Non-conductive flux.**

MADE IN USA

Typical Industrial Application: All types of relatively clean iron castings.

Note: See ADDIFIX 890 fact sheet for recommended welding techniques.

For Best Results: Always use short (2 inch maximum) stringer beads in a skip welding pattern. Keep the weld area as cool as possible by quenching with a wet rag. Always intensively, peen the deposited weldment after completing a bead. Veeing with 120 improves weldment strength and seals the cast iron surface for better bonding.