Addifix 880

NICKEL BASE ALLOY FOR GENERAL REPAIR OF CLEAN AND DIRTY, OILY CAST IRONS (AC/DC+)

Tensile Strength:	70,000-80,000 PSI			
Elongation:	**26-30 percent**			
Hardness:	**185 brinell**			
Diameters:	**3/32**	**1/8**	**5/32**	**3/16**
Amperages:	**95**	**120**	**145**	**170**

Advanced electrode for welding and overlay of cast iron at low temperature. For difficult repairs on heavy cast iron sections and for gray and alloy cast iron. Leak-proof deposit without hairline cracks on old, porous and oily cast iron. Joins cast iron to steel. Machinable deposit feathers beautifully into the base metal.

- **Amazing performance on old, dirty and oily cast iron.**
- **Porosity free deposit enables leak-proof repairs.**
- **Machinable weldments.**
- **An all position electrode to repair any cast iron.**
- **Joins cast iron to steel.**
- **Bonds securely to base metal at lower temperatures.**
- **Addifix 880 is the finest all around general purpose electrode available for joining, overlaying and building up cast iron.**

Typical Industrial Application: Castings, engine blocks, cylinder heads, transmission housing, molds, pump housing, machine bases, electric motor casings, gears, sluice gates, pillow blocks, fly wheels, pulleys, pedestals, manifolds, gear teeth, spokes, sprockets, valves, manhole covers, rings, pipes and joining steel pipe to cast iron flanges.

Note: ADDIFIX 120 cutting electrode is highly recommended for all weld preparation. Veeing with 120 improves weldment strength and seals the cast iron surface for better bonding. In extraordinarily oily or dirty situations use ADDIFIX 810 to butter and seal the casting's surface prior to applying ADDIFIX 880.

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.