



# Certanium 889SP

All position electrode for cast iron repair and joining and welding cast iron to steel.

## Features & Benefits

- All Position rod - Saves time in disassembling for repair
- Crack free results - Quality Repair
- Welds through rust and contamination - Saves preparation time
- Will weld mild steels - Ideal for joining dissimilar base metals
- No pre-heating required - Saves time

P/N	Product	S/C	Packaging
22001	Certanium 889SP 2.4 mm	889SP	4 kg
22003	Certanium 889SP 3.25 mm	889SP	4 kg

## Application

All cast irons including: Gray iron, Alloyed iron, Ductile, Nodular, Meehanite, and even steel to cast iron; recommended for machine bases, sprockets, housings, repair and build-up of broken and worn parts.

889SP's unique alloy composition and electrode construction helps provide crack resistant porosity free welds on cast iron without preheat. The bi-metal core wire construction allows 889SP to run on a wide amperage range without overheating. Because the electrode does not overheat, a soft smooth arc is produced, which will not snuff out or stick during operation. 889SP's controlled arc action reduces the size of the heat-affected zone.

889SP welds through oil, grease and other contaminants. This easy to control electrode produces smooth, dense, non-porous deposits that are easily machineable.

## Instructions

1. Guide the electrode at a steep angle keeping the arc length short.
2. Use short staggered beads when welding restrained parts. Weld spatter is minimal and slag deposits are virtually self-releasing.

P/N	Size	DC reverse / AC
22001	2.4mm	50-70
22003	3.25mm	70-100



## Technical Information

### General info:

**Consistency:** Solid  
**Base material:** Nickel  
**Colour:** Grey  
**Shelf life:** 3 years  
**Customs Tariff Code:** 83111010  
**VOC:** 0 g/l

**Tensile Strength:** 53 kg/mm<sup>2</sup>  
**Yield Strength:** 377 kg/mm<sup>2</sup>  
**Elongation:** 29%  
**Hardness:** Rockwell B 87-90

Diameter (mm)	Weldmetal/ Electrode (g)	Electrodes per Kg of Weldmetal	Arc Time of Deposition (min/Kg)	Current Setting (A)
3.25	21	47	49	90
2.5	13	80	100	70

All Weld Metal Analysis (Typical Weight %)									
C	S	Mn	P	Si	Misc	Cu	Fe	Al	Ni
1.90	0.03	<2.3	--	3.80	1 Max	2.30	<45	0.97	Balance



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REV: 29/05/2017