



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 6044

FEATURES & APPLICATIONS

For repair welding and overlay on all weldable cast iron grades to themselves and to join to low carbon steel alloys. Machining can be accomplished by using carbide tipped tools.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Mn	Si	C	Fe	Ni
.25	.15	.05	43.6	55.9

TYPICAL MECHANICAL PROPERTIES

Tensile Strength	89,500 psi (617 N/mm ²)
Yield Strength	62,000 psi (428 N/mm ²)
Elongation	35%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC- (electrode negative)

Diameter	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
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Welding Techniques:

Clean weld surfaces carefully to remove all scale and corrosion. Preheat and interpass temperature of 350°F (175°C) minimum is recommended during welding. Skip weld and peen weld bead thoroughly to remove stresses. Allow part to slow cool.