



# UNIBRAZE CastDM

## Description:

**UNIBRAZE CastDM** is a solid core welding electrode for the welding of most cast irons, including gray cast iron and spheroidal graphite cast iron parts as well as dissimilar metals (carbon steel, stainless). With a unique non-nickel series core rod, the weld zone of the reclaimed part is almost indistinguishable from the parent material after welding.

## Characteristics:

**UNIBRAZE CastDM** has an extremely smooth welding arc, and excellent slag fluidity. Weldability, crack resistance, as well as workability and mechanical properties are all excellent.

## Applications:

**UNIBRAZE CastDM** is commonly used on gears, motor housings, machine parts, farm equipment, large frames or any other cast iron part that needs to be welded to dissimilar metals such as carbon steel or stainless steel. Has excellent color match.

## Typical Mechanical Properties:

<b>Ultimate Tensile Strength (psi)</b>	84,000
<b>Percent Elongation %</b>	27
<b>Hardness</b>	180 HB

## Typical Deposit Composition:

<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>P</b>	<b>S</b>	<b>OTHER</b>
0.50	1.050	0.900	.019	.002	Bal

## Welding Positions:

Flat, Horizontal, Vertical Up.

## Typical Welding Procedures:

- 1) Use Direct from package or keep in oven. If exposed to moisture, dry at 450F for 1 hour.
- 2) Keep arc length as short as possible.
- 3) Do short length welds and peen before continuing.
- 4) For multi-layer beads, peen as much as possible to each layer.

## Welding Parameters: (AC or DC+)

<b>Diameter</b>	<b>Amperage</b>
3/32"	55-80
1/8"	80-100
5/32"	110-150

Notice: The results reported are based upon testing of the product under controlled laboratory conditions Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.