



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
7044
Nickel Iron MIG Wire

INTERNATIONAL CLASSIFICATIONS

None

FEATURES & APPLICATIONS

7044 is a universal wire for joining a wide variety of ductile, nodular and malleable cast irons. This alloy is ideally suited for the repair of defective or cracked malleable iron castings. This alloy can also be used for overlay, build-up and dissimilar welding applications such as cast iron to low alloy or carbon steels.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mo	Ni	Mn	Si	P	S	Cu	Fe
.05	.02	55.0	.25	.15	.001	.002	.13	44.0

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	89,500 PSI (617MPa)
Yield Strength	62,000 PSI (428MPa)
Elongation in 2"	35%

WELDING INSTRUCTIONS

Recommended Welding Parameters:

Short Arc:

Diameter	Amperage	Voltage	Wire Speed (ipm)	75% Argon / 25% He
.035"	70-90	18-20	150-200	30 (cfh)

.045"	75-160	19-22	175-225	30
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Spray Arc:

Diameter	Amperage	Voltage	Wire Speed (ipm)	100% Argon
.045"	190-250	30-32	300-350	35