



# Finalloys

## ACI 222 AC - DC (Straight)



THE FINEST "PULSED-ARC"  
SHALLOW PENETRATION  
MACHINEABLE ALLOY  
FOR ALL GRADES OF  
CAST IRON – MINIMIZES  
"HEAT - AFFECTED ZONE"  
HARDENING

FINALLOY ACI - 222 AC - DC (Straight)

### SPECIAL FEATURES

- EXCELLENT ARC CONTROL IN ALL POSITIONS
- GENERAL GLOBULAR ARC TRANSFER AT LOW TEMPERATURE
- EXTREMELY SOFT DEPOSITS DUE TO MINIMAL DILUTION
- ULTIMATE MACHINEABILITY

### INTERNATIONAL SPECIFICATIONS

AWS/ASME IIC SFA 5.15 E Ni-CI  
DIN 8573 E NiBG1  
ISO 171 E NiBG22



*The Final Welding Solution*

PRODUCT OF USA

## APPLICATIONS

- For all types of cast Iron.
- For rectification of casting defects and machining errors.
- Joining dissimilar sections.
- Excellent for old valve bodies, Pump Casting, Blocks, Housing, etc.
- All position welding

## MECHANICAL PROPERTIES OF ACI 222

### Undiluted Weld Metal

Tensile strength  
Yield strength  
Elongation

### Maximum Value up to

62,000 PSI (420 N /mm<sup>2</sup>)  
44,000 PSI (300 N/mm<sup>2</sup>)  
30%  
Rockwell B80-82, Brinell 150

## MICROSTRUCTURE

Austenitic nickel with finely distributed graphite flakes.

## WELD METAL ANALYSIS (Typical Weight %)for ACI 222

C	Al	Cu	Mn	Fe	Si	S	Ni
1.7	.63	.27	.79	1.2	2.8	.01	Bal.

Flux Color – Black

# Finalloy ACI - 222

### Finalloys (FZE)

SAIF - ZONE  
P O Box 514168 SHARJAH  
UNITED ARAB EMIRATES.

