

Got Cast Iron To Weld?

Welding cast iron is finally easy with Magna 770 rod. Starting at \$140/lb., the electrodes aren't cheap, but they do what other electrodes can't. They provide perfectly machinable welds on nearly all types of cast iron without preheating.

"Magna 770 welds have a much higher elongation, or stretch capability, than cast iron, so they won't crack," says Jimmy Morris of Brecko Corporation, the US distributor for Magna welding alloys. "And their 58,500 psi tensile strength is stronger than most cast iron."

They cost more than other rods, but Morris says "they're money-back guaranteed to do the job right, every time."

"The 770 can also be used as a transition rod between cast iron and steel", says Morris. A welder can build up a layer of the more expensive 770 and then weld a lower cost steel rod on top of it.

The rods are popular for repairing any type of cast iron that is not easily or cheaply replaceable, and when broken machinery needs to be put back in service immediately. Morris says "If you're welding on a fence or something cheap, we have another less expensive rod for that. The Magna 770 needs to be reserved for special situations"

The 770 comes in three sizes, 3/32", 1/8", and 5/32". It can be used with either AC or DC machines, and needs only 40 to 140 amps.

Morris says "We know the rods are expensive, so we sell by the piece if that's all the customer needs." He says the

Magna 770 in 1/8" rods are \$10 each, so an order for 5 rods would be \$50 for the rods and \$15 shipping, or a total of \$65.

There is a stronger rod, the Magna 777, which delivers 66,800 psi tensile strength, and is said to be slightly easier to machine. But Morris says "The Magna 777 rod is about 25% more expensive than the Magna 770, so I usually suggest the 770 unless that increase in tensile strength or machinability is really important".

Magna 720 for burned and dirty cast iron, is much less expensive than the other two electrodes at \$50 per pound. Morris says "It works well on exhaust manifolds, furnace grates or old wood stoves, or when machinability is not needed. Magna 720 burns deeper to get a bite in damaged cast iron, and the puddle freezes instantly" But it doesn't have the same high degree of elongation, and is slightly less crack-resistant. "The tensile strength is only 50,000 psi and it is a bit more difficult to work with. And it only comes in 1/8" size" according to Morris, "I guarantee it's not machinable. It's even hard on a grinder".

All Magna products are made by a subsidiary of Illinois Tool Works. Other Magna rods are also designed for specialized applications. "Magna 303 steel rods will weld any steel to any steel and are stronger than any other rods we can find, with tensile strength as great as 128,000 psi - they even work harden to 180,000 psi", says Morris. "It's a weld you simply can't break".

Magna 307 for mild steel can be used in wet and restricted or dirty environments. It



Magna 777 rod provides machinable welds that won't crack on most types of cast iron. Photo shows a steel valve welded to a cast iron pump.

can be used to weld pipes with fluid in them. Morris says using the 307 is easy, even for inexperienced welders because you can use direct contact and it will not "stick". And they're as low as \$35 per pound for 1/8"

Brecko sells all Magna electrodes out of open stock, by the piece or by the pound. A standard \$15 shipping charge is added to orders whether for a single rod or 10 lbs.

"Call to discuss your project" says Morris. "We can help you pick the rod that is best for your needs. And we have direct access to the Magna corporate engineers if a customer needs it."

Contact: FARMSHOW Followup, Brecko Corp., 209 N Mockingbird, Abilene, Texas 79603 (ph or 800 720-2887; breckocorp@yahoo.com; www.breckocorp.com); in Canada: Eldon Welding Systems, 41 Scotia St., Winnipeg, Manitoba Canada R2W 3W6 (ph 204 586-8336; eldonwld@mymts.net).

Reader Inquiry No. 102

Shockerhitch

A Simple Idea That Makes Trailers Tow Smooth

The all new 5th Wheel Cushioned Hitch from Shocker Hitch just clicks on to the front of the camper fast and easy. "The ride improvement is amazing." Says Bob Sagen, president of Shockerhitch, Inc. "At Shocker Hitch we are mostly known for our Receiver hitches and our Gooseneck Surge hitch. Well, it is time for a new frontier. We took the knowledge we have gained over the years with our gooseneck hitch and applied it to a 5th Wheel hitch, basically, we know what works. If you tow one of these campers, you are well aware of the push pull effect that comes from towing a large trailer." The new 5th Wheel Cushion Hitch uses a three step process to control the violent push and pull. The result is a



much smoother and more comfortable ride.

Contact: FARM SHOW Followup, Shockerhitch, Inc., P.O. Box 172, Arthur, N. Dak. 58006 (ph 701-967-8577; www.shockerhitch.com).



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