

GLEASON CRANKSHAFT JOURNAL REBUILDING KITS

Passenger Car Kits

Non-Heat Treated under HRC 30

Each kit welds approximately 150-175 journals

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
#1 Jumbo Kit	KASTALLOY BUILD UP KIT (Jumbo Size) This material is intended for all grades of Cast Iron and chemically heat treated (nitrided or tufftrided) high performance forged steel and billet steel. No pregrinding necessary for cast or steel Kit contents: 30 lbs (13.61kg) wire 75 lbs (34.02kg) flux	.030" (.76mm) .035" (.89mm) .045" (1.14mm) (Specify diameter when ordering)	20	834.75
#1 Sample Kit	KASTALLOY SAMPLE KIT Kit contents: 2 lbs (.9kg) wire - 20 lbs(6.8kg) flux	.035" (.89mm)	20	75.00
#5, #7, #8 Kit	UNIVERSAL BUILD UP KITS For most passenger car shafts incl. Cast iron & mild forged steel under HRC 30. Kit contents: 30 lbs (13.61kg) wire 70 lbs (31.75kg) flux	.030" (.76mm)	20 Steel 45 Nod. Iron	569.00
#6 Kit	HIGH PERFORMANCE KIT For chrome molly steel forgings, billet steel racing applications. Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.035" (.89mm) .045" (1.14mm) (Specify diameter when ordering)	30	616.00
#1135A Kit	FORGED STEEL (work dia. 3" /76 mm or less) Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.035" (.89mm)	20 - 25	556.95
#1145B Kit	FORGED STEEL (work dia. 3" /76mm or more) Kit contents: 25 lbs (11.34kg) wire 63 lbs (28.58kg) flux	.045" (1.14mm)	20 - 25	556.95

GLEASON SPECIALITY JOURNAL BUILD UP KITS

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
#316ELC Kit	FOOD SERVICE GRADE STAINLESS STEEL Kit contents: 30 lbs (13.61kg) wire 75 lbs (31.75kg) flux	.035" (.89mm)	30	834.75
#1635E Kit	INDUSTRIAL/MARINE GRADE NON-FOOD SERVICE STAINLESS STEEL Kit contents: 30 lbs (13.61kg) wire 75 lbs (31.75kg) flux	.035" (.89mm)	30	834.75
#2035K Kit	HEAT TREATABLE GEAR STEEL Kit contents: 20 lbs (9.07kg) wire 63 lbs (28.58kg) flux	.035" (.89mm)	60	926.75

OPERATING INSTRUCTIONS ARE INCLUDED INSIDE EACH KIT.

Do not use any other combination of flux or wire other than is supplied with Kit

Any substitution will change the chemistry and may result in serious problems or crankshaft breakage

GLEASON CRANKSHAFT JOURNAL REBUILDING KITS

Diesel Kits

Heat Treated Induction Hardened Forged Steel Crankshafts Non-Fillet Hardened Over 30 HRC

These kits are intended for use on crankshafts that are induction hardened on journal area only.
Each kit welds approximately 75 – 100 journals

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
# 2235HD Kit	DIESEL KIT (Work dia. 3"/76 mm or less) Kit contents: 10 lbs. (4.54kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.035" (.89mm)	30 RADIUS 52 JOURNAL	1015.25
# 2245HD Kit	DIESEL KIT (Work dia. 3"/76 mm or more) Kit contents: 10 lbs. (4.54kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.045" (1.14mm)	30 RADIUS 52 JOURNAL	1015.25
# 2235HD/25 Kit	DIESEL KIT WITH 25 lb. RADIUS WIRE (Work dia. 3"/76 mm or less) Kit contents: 25 lbs. (11.34kg) Radius wire 20 lbs. (9.07kg) Journal wire 25 63 lbs. (28.58kg) flux 13.80	.035" (.89mm)	30 RADIUS 52 JOURNAL	1169.00
# 2245HD/25 Kit	DIESEL KIT WITH 25 lb. RADIUS WIRE (Work dia. 3"/76mm or more) Kit contents: 25 lbs. (11.34kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.045" (1.14mm)	30 RADIUS 52 JOURNAL	1169.00
#4 MARINE OUTBOARD Kit	MARINE OUTBOARD (Work dia. 3"/76 mm or less) Kit contents: 10 lbs. (4.54kg) Radius wire 20 lbs. (9.07kg) Journal wire 63 lbs. (28.58kg) flux	.035" (.89mm)	30 RADIUS 65 JOURNAL	1029.25
#4 MARINE OUTBOARD Sample Kit	OUTBOARD SAMPLE (Work dia. 3"/76 mm or less) Kit contents: 2 lbs. (.90kg) Radius wire 2 lbs. (.90kg) Journal wire 20 lbs. (6.80kg) flux	.035" (.89mm)	30 RADIUS 65 JOURNAL	169.45

Special Application Diesel Kits

Heat Treated Induction Hardened Forged Steel Crankshafts Fillet Hardened Over 30 HRC

These kits are intended for use on crankshafts that are induction hardened on journal and radius/thrust area. Each kit welds approximately 75 – 100 journals

KIT NUMBER	KIT DESCRIPTION	WIRE DIA.	RC HARDNESS	PRICE
# 2235HD CAT Kit	DIESEL KIT (Work dia. 3"/76 mm or less) This kit contains special "RADIUS 26" WIRE FOR WELDING FILLET HARDENED RADIUS Kit contents: 25 lbs. (11.34kg) Radius wire 20 lbs. (9.07kg) Journal wire 100 lbs. (45.36kg) flux	.035" (.89mm)	30 RADIUS 55 JOURNAL	1,326.25
# 2245HD CAT Kit	DIESEL KIT (Work dia. 3"/76 mm or more) This kit contains special "RADIUS 26" WIRE FOR WELDING FILLET HARDENED RADIUS Kit contents: 25 lbs. (11.34kg) Radius wire 20 lbs. (9.07kg) Journal wire 100 lbs. (45.36kg) flux	.045" (1.14mm)	30 RADIUS 55 JOURNAL	1,326.25

OPERATING INSTRUCTIONS ARE INCLUDED INSIDE EACH KIT.

Do not use any other combination of flux or wire other than is supplied with Kit

GLEASON QUALITY ELECTRODE WIRE & FLUX

Electrode Wire

WIRE #	WEIGHT	WIRE DIA.	PRICE
#1	30 lbs. (11.34kg)	.030" / .035" / .045" (.76mm / .89mm / 1.14mm)	513.00
#5	30 lbs. (13.61kg)	.030"(.76mm)	271.50
#6	25 lbs. (11.34kg)	.035"(.89mm)	348.25
#7	30 lbs. (13.61kg)	.030"(.76mm)	279.50
#8	30 lbs. (13.61kg)	.030"(.76mm)	271.50
1135A	25 lbs. (11.34kg)	.035"(.89mm)	289.20
1145B	25 lbs. (11.34kg)	.045"(1.14mm)	289.20
1635E	25 lbs. (11.34kg)	.035"(.89mm)	513.00
2035K	20 lbs. (9.07kg)	.035"(.89mm)	659.00
2235D RADIUS/10	10 lbs. (4.54kg)	.035"(.89mm)	102.50
2235D RADIUS/25	25 lbs. (11.34kg)	.035"(.89mm)	256.25
2235HD JOURNAL	20 lbs. (9.07kg)	.035"(.89mm)	645.00
2245D RADIUS/10	10 lbs. (4.54kg)	.045"(1.14mm)	102.50
2245D RADIUS/25	25 lbs. (11.34kg)	.045"(1.14mm)	256.25
2245HD JOURNAL	20 lbs. (9.07kg)	.045"(1.14mm)	645.00
2235D RADIUS/26	25 lbs. (11.34kg)	.035"(.89mm)	348.25
2245D RADIUS/26	25 lbs. (11.34kg)	.045"(1.14mm)	348.25
316 ELC	25 lbs. (11.34kg)	.035"(.89mm)	513.00
#4 OUTBOARD JOURNAL	20 lbs. (9.07kg)	.035"(.89mm)	659.00

Submerged Arc Flux

FLUX #	FULL KIT CONTAINS	PRICE/LB.	PRICE
#1	70 lbs. (31.75kg)	4.25	297.50
#6	63 lbs. (28.58kg)	4.25	267.75
#10	63 lbs. (28.58kg)	4.29	270.27
1635E	63 lbs. (28.58kg)	4.25	267.75
316 ELC	63 lbs. (28.58kg)	4.25	267.75

SUPPLIERS OF CRANKSHAFT REBUILDING MACHINERY AND JOURNAL BUILDUP MATERIALS