

Applications

Repair of cast iron & engine blocks re-building worn surfaces joining cast iron to steel.

Characteristics on Usage

This is a light coated graphite based electrode for welding cast iron without preheating and for getting machinable weld on cast iron. the electrode gives a nickel copper (Monel) deposit.

Notes On Usage

- 1) Chip off base metal completely at the repairing part .
- 2) There is possibility that cracks spreads or makes holes at both ends of repairing part .
- 3) Keep the weld metal length less than 50 mm (2 inch) to disperse welding heat- adopt back stepping stone or symmetry method by turns.
- 4) The preheat temprature vary in accordance with te size ,king and shape of the base metal 150°C is appropriate in general .

Welding Positions

1G 2F

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni %	Cu %	Fe%
0.70-1.30	0.60 Min	0.60 Max	0.030 Max	0.030 Max	64.0-70.0	Bal.	2.0-4.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	HARDNESS
300-400	150 BHN

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	2	10	AC / DC (+)	60 - 70
3.15 X 350	2	10		70 - 100
4.00 X 350	2	10		100 - 140
5.00 X 350	2	10		

Packing

Vaccum packing