

Applications

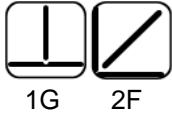
It is suitable for welding of variety of cast iron like grey, S.G. iron components. Suitable for cold welding for engine components, Blocks, Pump casing, Impellers gears, Sprockets, Valve bodies, Cast iron machine base, filling in sand pockets and drill holes as well as surfacing.

Characteristics on Usage

ROYAL CAST – N is an outstanding electrode depositing pure Nickel for machinable welding of cast iron. The weld deposit is soft and has good resistance to cracking. It is used for welding of cast iron to produce machinable weld deposits. It is an all position electrode gives excellent bonding of weld metal with cast iron or dissimilar metal parts.

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**Chemical Composition Of Weld Metal**

C%	Mn%	Si%	S%	P%	Ni %	Fe%
2.00 Max	2.50 Max	4.00 Max	0.030 Max	Traces	85.00 Min	8.00 Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	HARDNESS
300 – 400	150 VPN

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 X 350	2	10	AC / DC (+)	40 - 60
3.15 X 350	2	10		80 – 110
4.00 X 350	2	10		90 – 130
5.00 X 350	2	10		140 – 180

Packing

Vaccum packing