

Applications

It is used for welding Gears, Cracked motor or generators housing. It is used for repair works of cast iron, carbon steels, mild steels parts.

Characteristics on Usage

A medium heavy coated low hydrogen type electrode for all types of cast iron where machinability is not essential for welding basis on cast iron. It gives high strength where a strong and rigid joints is required in between two cast iron parts. Suitable for joining of cast iron to carbon and low alloy steels.

Notes On Usage

- 1) Preheat temperature vary in accordance with shape and size of base metal
- 2) Preheat at 200-350 °C gradual Cooling recommended after welding.

Welding Positions

1G 2F

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	60 - 80
3.15 x 350	5	20		100 - 140
4.00 x 450	5	20		140 - 180
5.00 x 450	5	20		180 - 230

Packing

Vaccum packing