

AN EXCELLENT ELECTRODE FOR REPAIR OF CASTING DEFECTS AND WITH OPTIMUM MACHINABILITY

Alloy Basis

Ni, C, Fe

Characteristics :

Electrode with excellent welding characteristics. The deposit is Machinable and crack-proof. Good bonding on difficult to weld cast iron.



Typical Applications

Electrode for cold welding of cast iron without preheat and for joining cast iron to mild steel. Also suitable for surfacing cast iron parts subject to erosion, corrosion and high temperatures. Best suited for repairing intricate cast iron parts, water pump housing, electric motor bodies and covers, machine frames, cylinder blocks and gears. Also ideal for salvaging foundry castings, gear box, differential housing, lathe beads, sugar mill rollers, glass moulds and cast iron dies.

Mechanical Properties

Tensile Strength : 340 – 445 MPa

Welding Current : AC, DCEN

Size (Ø mm)	3.15 mm	4.00 mm
Current (amps)	70 - 100	100 - 130

Availability:

Standard Size: 5.0, 4.0, 3.2 in 350 mm length

Packing: 2 kg.

Procedure

Clean the welding surface for cracks and defects. Drill holes at ends of crack and vee out using SME I00. Use a short arc with low current to deposit stringer beads 25 to 75 mm long at a time. Hot Peen the deposit to reduce residual stresses. Use skip welding technique. Cool slowly.