

ELECTRODE FOR REPAIRING GREY CAST IRON, MODULAR IRON AND JOINING CASTING TO STEEL

Alloy Basis

Ni

Characteristics :

This electrode is ideal for joining or rebuilding cast iron surfaces where low heat input and resistance to stress and vibration are critical. It offers Controlled penetration with smooth stable arc and produces machinable deposits.



Typical Application

Used for repairing cracked or worn cast iron parts such as engine blocks, cylinder heads, pump housings and other cast iron components. Excellent for joining pure cast iron to itself or to low alloy steel or mild steel components.

Technical Data:

Tensile strength: 30 - 38 kgf/mm²

Welding Current : AC, DCEN

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	50 - 75	70 - 90	100 - 140	150 - 190

Availability:

Standard Size : 5.0, 4.0, 3.15 & 2.50 in 350 mm length

Packing : 2 Kg

Procedure

Clean the surface to remove rust, oil, dirt, grease, and any other contaminants. Preheat the work piece to a temperature of around 200-250°C. Use a short arc with low current to deposit a stringer bead not exceeding 50 mm. Peen the deposit to reduce residual stress