



CASTEN

CAST IRON



Non Machinable Electrode for General Reclamation and Repair of Cast Iron

CLASSIFICATION : AWS A/SFA 5.15

ISO 1071

E St

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KEY FEATURES :

- Low hydrogen type electrode
- Ni free non machinable deposit
- Improved crack resistivity
- Strong and rigid joint between cast iron parts
- Excellent colour match to cast iron
- Preheating is recommended for heavy and complicated sections
- Ideal as a base layer to seal contaminations

WELDING POSITION :



AC (45 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Welding of cast iron parts for all types of general reclamation or repair work
- Repairing foundry defects
- Guards on machine tools
- Cast iron furnace equipment
- Sealing oil-soaked cast iron parts
- Motor and generator housings
- Joining cast iron to mild steel
- Suitable for thin and thick sections

REDRYING CONDITION : 250°C for 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P	Fe
Typical	0.1	0.5	0.1	0.03	0.03	Rem.
Specification	0.15 max.	0.6 max	0.15 max	0.04 max	0.04 max	Rem.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	3 Layer, Hardness, BHN
Specification	As Welded	240-290

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 350	60-90	5	4	20
3.15 x 450	100-140	5	4	20
4.0 x 450	140-190	5	4	20
5.0 x 450	190-250	5	4	20