



CASTEN

CAST IRON

AWS A/SFA 5.15 **Est**

CLASSIFICATION:

ISO 1071
E C St 1

IS 5511
E Fe B26

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

APPROVALS: CE

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


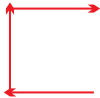
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	0.6	0.15

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	Hardness, BHN
Specification	As Welded	250-400

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	60-90	 AC (70 OCV)/ DCEP	All Positions, except vertical Down 
3.15 x 350	100-140		
4.0 x 350	140-190		
		REDRYING CONDITION: 250°C for 1 hr.	

Available in Standard carton packing of 20 kg box containing 5 cartons of 2 kg each.