



CASTFERRINICKEL

CAST IRON



Special Welding Electrode For Nodular and Malleable Cast Iron

KEY FEATURES :

- Low heat input electrode
- Ni-Fe type weld deposit
- Tough and machinable deposit with adequate strength and hardness
- Sound and porosity free welding
- Controlled penetration ensure good bonding
- No preheating required even for large complicated castings
- Perfect color match with base metal

WELDING POSITION :



AC (45 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Special electrode for repair welding of Nodular and Malleable cast iron
- Building up worn out cast iron parts
- Rectification of machining errors on castings
- Repair of broken heavy castings
- Excellent for joining cast iron to steel
- Foundry defects such as shrinkage, cavities, blow holes, missing sections
- Gear boxes, Gear teeth, Valve body
- Couplings, Sprockets
- Cast iron dies, Machine bases
- Pumps and Differential housings
- General welding of very heavy sections

REDRYING CONDITION : 150°C for 1 hr.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	Hardness (3 Layer), BHN
Range	As Welded	150-200

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 300	40-70	1	10	10
3.15 x 300	70-110	1	10	10
4.0 x 300	90-120	1	10	10