

CASTMONEL

AWS A/SFA 5.15 ENiCu-B

CAST IRON

CLASSIFICATION:

ISO 1071
E C NiCu-B1

IS 5511
E NiCu2 G33

KEY FEATURES:

- Graphite based coating
- Monel type weld deposit
- Machinable weld
- Minimum dilution ensures shallow but sufficient depth of fusion
- No need of preheating

APPROVALS: CE

TYPICAL APPLICATIONS:

- Repair of cast iron castings
- Well suited for Gears, machinery parts, Pump bodies
- Rebuilding worn surfaces
- Joining cast iron to steel
- Correcting machining errors on castings



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Cu
0.43	1.1	0.7	3.1	63	31.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	3 Layer, Hardness, BHN
Specification	As Welded	200 max

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 45-60 90-110 120-150	 AC (70 OCV)/ DCEP REDRYING CONDITION: 150°C for 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 10 kg box containing 1 cartons of 10 kgs each.