

CAST FN

A universal Nickel-Iron alloy electrode for welding of Cast Iron

CLASSIFICATION : AWS/SFA-5.15: E Ni Fe CI , DIN E NiFeG3

CHARACTERISTICS : A medium coated, ferro-nickel core wire electrodes specially designed to weld cast iron components in cold conditions. The deposit is soft and machinable, retains strength, enable to weld large cast iron castings, produces crack free joints.

APPLICATION :

- 1) Suitable to weld and repair all types of Cast Iron components.
- 2) Broken casting, joining cast iron to steel.
- 3) Cast iron components subjected to wear and tear etc.
- 4) Also suitable for underplaying of Hardfacing.

RE-DRY CONDITION : Re-Dry the electrode at 150°C for 1 hour.

WELDING PRECAUTIONS :

1. clean the weld area free of any surface contaminations.
2. preheating of the job between 250°C - 500°C may be necessary according to the amount of weld metal to be deposited and the size and type of casting.
3. After the welding is completely with a layer of asbestos or dry lime until it attains room temperature.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	Ni	Fe
0.80-2.00 Max	1.00 Max	1.00 max	50 Min	Bal.

WELD METAL HARDNESS:

Hardness
170-190 VPV

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+ / AC) Amps	Wt. of /pkt.	Wt. of Case
2.50/ 2.40 X 350	3/ 32" X 14"	50-70	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	130-180	2	20

Customer packing on request.