

CAST STEEL

Hydrogen controlled, Basic coated Electrode for Non-Machinable weld on cast Iron

CLASSIFICATION : AWS/SFA-5.15: Est (Nr.)

APPROVAL :

CHARACTERISTICS : A hydrogen controlled, medium heavy coated electrode, laying non-machinable weld deposits on cast iron. The electrode needs the components to be pre-heated in case they are heavy and complicated sections. Gives strong and rigid weld joints.

APPLICATION :

- 1) Suitable to weld mild steel to cast iron parts.
- 2) Repair works on cast iron where machining is not of importance and primary consideration

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

WELDING PRECUATIONS :

1. clean the weld area free of any surface contaminations.
2. For heavy and complicated sections, preheat to minimum temperature of 400°C is recommended.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si
2.00-3.00 Max	0.60 Max	4.00-6.00 max

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"	60-80	5	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-110	5	20
4.00 X 350	5/ 32" X 14"	110-130	5	20
5.00 X 350	3/ 16" X 14"	140-180	5	20

Customer packing on request.