

Classifications

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|------------------|---------------|------------|---------|
| EN ISO 1071:2003 | : E C Ni-CI 1 | KS D 7008 | : DFCNi |
| AWS A 5.15-90 | : ENi-CI | JIS Z 3252 | : DFCNi |

Description

- Covering is graphite type for repairing and joining of various kinds of cast iron products such as cylinder covers, motor beds, casings and gears or repairing co cast iron, alloy cast iron and malleable cast iron.
- Easily machinable deposited weld metal.
- Chip off base metal completely at the repairing part.
- Preheat at 150~300°C. The temperature to be applied varies in accordance with kind, shape and size of base metal.
- Redry the electrode at 70~120°C for 30~60 minutes prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

| C | Si | Mn | P | S | Ni | Cu | Fe | Al |
|------|------|------|-------|-------|------|------|------|------|
| 0.55 | 0.40 | 0.35 | 0.009 | 0.001 | Rem. | 0.05 | 0.85 | 0.05 |

Typical mechanical properties of all-weld metal

| T.S (MPa) | HV | Hardness HB | HS |
|--------------|---------|----------------|-------|
| 420 | 160~190 | 152~181 | 24~28 |

Sizes available and recommended currents (AC or DC +)

| Dia. Length | (mm) (mm) | 2.6 300 | 3.2 350 | 4.0 350 | 5.0 550 |
|----------------|--------------|------------|------------|------------|------------|
| Amp. (A) | F | 60~90 | 70~110 | 110~130 | 130~150 |

Approvals

CE