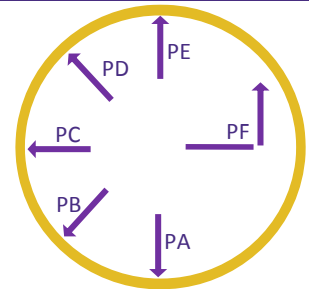


Applications

- Graphite coated electrode with Ni alloy core rod used for AC/DC in all position welding
- Repairing and joining of cast iron

Features

- Graphite coated electrode
- Preheat at 150°C (302°F)



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	Ni	Al	S	Cu	Fe
1.05	0.97	0.13	90.8	0.3	0.02	1.5	4.5

Typical Mechanical Properties of All-Weld Metal

Ys MPa	TS MPa	EL (%)	Hardness
348	395	5	77.6

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	300 (14)	350 (18)	350 (18)	350 (18)
F	60-80	70-120	100-150	130-170

Current

AC or DC ±

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Notes on Usage

- To repair a defect, it must be removed completely by machining or grinding before welding.
- Stringer welding with the maximum bead length 8cm is recommended to prevent overheat, distortion and cracking.
- Backstep, symmetrical or intermittent sequence is recommended for a long welding line to prevent cracking.

Packing Details

2Kg Pack / 10 Kg Ctn (Vaccum Packing)