



CASTRON KALT

CAST IRON ELECTRODE

CLASSIFICATION : AWS / A 5.15 : E Ni CI

APPROVALS : BHEL

CHARACTERISTICS : A pure nickel core wire electrode designed for welding of cast irons with minimum or no preheat. Weld deposit is very soft but tough and easily machinable. Globular metal transfer and low penetration are special features.

APPLICATIONS :

- * Reclamation of Defective Castings
- * Joining of Cast Iron to Steel, Monel & Copper
- * Filling up Small Cavities.
- * Repairs of Damaged/Cracked Castings.

RECOMMENDATIONS : Select the smallest size of electrode, use low current and deposit thin layers to avoid overheating. Peen the weld beads whilst warm. Cool the welded part under insulation.

CHEMICAL ANALYSIS OF WELD-METAL (%) :	C	Mn	Ni	Fe
	0.1-2.0	0.50 max	92-96	4-6

HARDNESS : 200 BHN max

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5x350	3.15x350	4.0x350	5.0x350
Amps	40-70	70-100	100-130	130-170



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