



MODI XL NiCu

CAST IRON ELECTRODE

CLASSIFICATION : AWS/A 5.15 : E Ni Cu B

CHARACTERISTICS : An electrode with nickel-copper alloy wire specially designed for welding of cast iron parts. In view of the balanced flux formula this electrode is more suitable for all impregnated cast-iron jobs. Multipass welding can be done. The weld metal is free from cracks and has best colour match with parent metal.

APPLICATIONS :

- Machine Bases, Engine Blocks
- Pump and Transmission Houses
- Repairs of Gears
- Joining of Cast irons to Steels as well as Non-Ferrous materials

RECOMMENDATIONS : Preheating of job to 100°C will give best result. Use stringer beads and lowest possible amperage with backstep sequence. Peen the weld bead after every 2-3 inches of welding. Avoid overheating of the job.

CHEMICAL ANALYSIS OF WELD METAL (%)

	C	Mn	Si	Ni	Cu
	0.35-0.55	2.3 max	0.75 max	60-70	25-35

HARDNESS : On 3 Layer Deposit : 200 BHN max

CURRENT CONDITIONS : USE AC OR DC (+)

Size (mm)	2.5 x 350	3.15 x 350	4.0 x 350	5.0 x 350
Range (Amps.)	40-70	70-100	100-130	130-170



WELD EXCEL INDIA LTD.

D-230, Phase VII, Focal Point,
Ludhiana - 141 010

Phone : (0161) 3259335 Telefax : 0161-2677459

Manufactured under licence from :
MODI ARC ELECTRODES CO.
(A UNIT OF MODI INDUSTRIES LTD.)
MODINAGAR (U.P.) 201 204