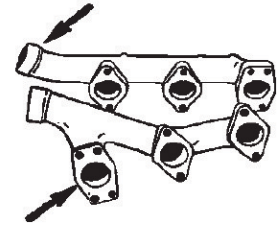


Nickel free cast iron problem solver, seals in porosity generating contaminants prior to finish welding with nickels.



- ❑ Easily clads heat oxidized and oil impregnated castings
- ❑ Perfect color match to cast iron
- ❑ Non-conductive flux coating

INTERNATIONAL SPECIFICATIONS	AWS/ASME A 5.15: ESt DIN 8573: E Fe-1 ISO 1071: E Fe

#### APPLICATIONS:

For non-machinable welds on machine bases, furnace grates, exhaust manifolds, etc.

#### ALL WELD METAL ANALYSIS (Typical Weight %):

C	Mn	Si	S	P	Fe
.12	.58	.02	.03	.03	bal

FLUX COLOR: Black

**TYPICAL MECHANICAL PROPERTIES:****Undiluted Weld Metal**

Tensile Strength

Yield Strength

Elongation

Hardness

**Maximum Value Up to:**62,000 PSI (440 N/mm<sup>2</sup>)50,000 PSI (360 N/mm<sup>2</sup>)

20%

Brinell 380, Rockwell C39

**RECOMMENDED CURRENT:** DC Reverse (+), AC**RECOMMENDED AMPERAGE SETTINGS:**

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	45	70	95
Maximum Amperage	85	125	150

**WELDING POSITIONS:** Flat, vertical up, horizontal, vertical down, overhead**DEPOSITION RATES:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting	Recovery Rate
3/32 (2.5)	14" (350)	.30oz (8g)	53 (117)	36 (79)	70	100%
1/8 (3.25)	14" (350)	.62oz (17g)	26 (57)	25 (55)	100	100%
5/32 (4.0)	14" (350)	1oz (28g)	16 (35)	20 (44)	135	100%

**WELDING TECHNIQUES:**

Use stringer or moderate weave technique. When cladding, cover the entire base surface prior to finish welding.