



CASTMONEL

CAST IRON

AWS A/SFA 5.15 ENiCu-B

CLASSIFICATION:

ISO 1071

E C NiCu-B1

IS 5511

E NiCu2 G33

KEY FEATURES:

- Graphite based coating
- Monel type weld deposit
- Machinable weld
- Minimum dilution ensures shallow but sufficient depth of fusion
- No need of preheating

APPROVALS: CE

TYPICAL APPLICATIONS:

- Repair of cast iron castings
- Well suited for Gears, machinery parts, Pump bodies
- Rebuilding worn surfaces
- Joining cast iron to steel
- Correcting machining errors on castings


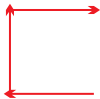
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Fe	Ni	Cu
0.43	1.1	0.7	3.1	63	31.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa
Typical	As Welded	350

PARAMETERS - PACKING DATA:

<p>Ø x L, mm</p> <p>2.5 x 350</p> <p>3.15 x 350</p> <p>4.0 x 350</p>	<p>Amperage, A</p> <p>45-60</p> <p>90-110</p> <p>120-150</p>	<p> AC (70 OCV)/ DCEP</p> <p>REDRYING CONDITION: 150°C for 1 hr.</p>	<p>All Positions, except vertical Down</p> 
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Available in Standard carton packing of 10 kg box containing 1 cartons of 10 kg each.