



CASTEN

CLASSIFICATION

AWS A/SFA 5.15 E St
 IS 5511 E Fe B26

COATING TYPE: Basic

COATING FACTOR: Medium IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)				
6.3	5.0	4.0	3.2	2.5
250-	190-	140-	100-	60-
330	250	190	140	85

CHARACTERISTICS

A low hydrogen type electrode for non-machinable welds on cast iron. The electrode should be preferred when a strong and rigid joint is to be obtained between two cast iron parts. The electrode operates in all positions except vertical down. Pre-heating is recommended for heavy and complicated sections.

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

250°C for 1 hour (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

TYPICAL APPLICATIONS

Welding of cast iron parts for all types of general reclamation or repair work, where machinability is not a primary consideration. Joining cast iron to mild steel etc.

WELD METAL CHEMISTRY, wt%

C - 0.15 max.	Fe - Rem.
Si - 0.15 max.	S - 0.03 max.
Mn - 0.60 max.	P - 0.03 max.

PACKING DATA

Dia.,mm	5.0	4.0	3.2
Length,mm	450	450	450
Wt. per carton, kgs	5.25	5.25	5.25
Cartons/ box	4	4	4
Wt. per box, kgs	21	21	21