

# SPECIAL ALLOYS FOR MAINTENANCE & REPAIR

## ELECTRODES

For Welding Cast Iron

### PRODUCT GOLD : 410



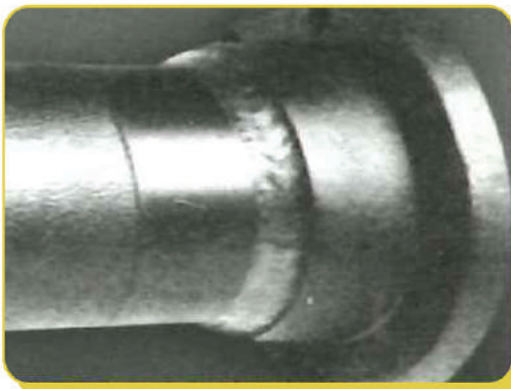
Descriptions	Technical Details	Ømm	List Price
<b>Electrode for cold repair welding of most different types of cast iron.</b> Use for welding and rebuilding of frames, gear box, machine and pump housings, engine blocks, casting defects, pulleys, compressors. Excellent machinability  Weld metal composition : Ni>95, Fe, Mn, C, Si	Rm (Mpa): 350	2.6	
	Hardness : ~180 HB	3.2	
		4.0	



### PRODUCT GOLD : 420

Descriptions	Technical Details	Ømm	List Price
<b>High strength Fe Ni Alloy electrode for cold welding of different Cast irons such as grey cast iron nodular cast iron and for joining cast iron to steel. Electrode will not overheat and has exceptional good mechanical properties. Can also be used as a bonding layer on dirty or oily cast iron.</b> Weld metal composition : Ni, Fe, Mn, C, Si <b>Base Metal:</b> Grey cast iron ASTM A48 class 25 B-60 B, A536 Grade 60-80 DIN GG15-GG40, GGG 40 TO 60, GTS 35 to 65	Rm (Mpa): 550	2.6	
	Re (Mpa) : 350	3.2	
	A5 (%) : 15	4.0	
	Hardness :		
	200 ~ 220 HB		

### PRODUCT GOLD : 707



Descriptions	Technical Details	Ømm	List Price /kg
<b>Economy type Nickel base Electrode for repair and fabrication of cast iron components.</b> Recommended for welding gray, nodular and malleable cast iron and for joining cast iron to steel. GOLD 707 is one of the <u>most economic electrodes</u> for welding of cast-iron.	Rm (Mpa): 420	2.6	
	Re (Mpa) : 350	3.2	
	A5 (%) : 15	4.0	
	Hardness :		
	200 ~ 220 HB		