

Electrodes for Welding Cast Iron

PRODUCT M&R	DESCRIPTIONS	TECHNICAL DETAILS	Ømm	APPLICATIONS
420	<p>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.</p> <p>Electrode will not overheat and has exceptional good mechanical properties. Can also be used as a bonding layer on dirty or oil cast iron.</p> <p>Base Metals: Grey cast iron ASTM A48 class 25 B-60B, A536 Grade 60-80 DIN GG15-GG40, GGG 40 to 60, GTS 35 to 65</p>	<p>Rm (MPa): 550 Re (MPa): 350 A5 (%): 15 Hardness: 200-220 HB</p> <p>Weld metal composition: Ni, Fe, Mn, C, Si</p>	<p>2.6 3.2 4.0</p>	