



**JACKSUN CAST(M)
CAST ALLOY**



Ni-Fe Type Electrode for Repair and Welding of Cast Iron.

CLASSIFICATION:

AWS A/SFA 5.15

IS 5511

APPROVALS

E NiFe-CI

E Ni Fe G16

CE / BIS/IBR/BHEL/IRS/

KEY FEATURES :

- Ni-Fe type machinable electrode
- Dense, soft, and ductile weld with adequate strength
- Porosity free welding
- Excellent color match to cast iron
- No need of preheating for large heavy castings

WELDING POSITION:

WELDING POSITION :



AC (45 OCV)/ DCEP

TYPICAL APPLICATIONS:

- Repair of broken heavy castings
- Welding and repairing of all cast iron components
- Pump casting and gears, Cast iron dies, Gearboxes, Gear teeth.
- Transmission housings, Couplings
- Foundry defects, Machine build up
- Best suited for welding of Nodular graphite iron, Malleable iron subject to heavy wear.
- Excellent color match to cast iron
- Preheating is recommended for heavy and complicated sections
- Ideal as a base layer to seal contaminations

REDRYING CONDITION: 250-300OC for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METALWt% :

	C	Ni	fe	Mn	Si	S	Cu	Ai
Typical	1.1	52	Bal.	1.2	1.5	0.02	0.5	0.03
Specification	2.0 max	45.0-60.0	Bal	2.5 max	4.0 Max	0.03 Max	2.5 max	1.0 max

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	Hardness(3 Layer), BHN
Specification	As Welded	150-190

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage,A	Wt./Carton kg	Carton/Bo x	Approx. wt. of 1000 pcs, Kg.
2.5 x 300	40 - 70	1	12	12
3.15 x 350	70-110	1	12	12
4.0 x 450	90-120	1	12	12