



**JACKSUN CAST(N.M).**  
**CAST ALLOY**



Non Machinable Electrode for General Reclamation and Repair of Cast Iron

**CLASSIFICATION:**

AWS A/SFA 5.15

IS 5511

APPROVALS

Est

E Fe B26

CE / BIS/IBR/BHEL/IRS/

**KEY FEATURES :**

- Low hydrogen type electrode
- Ni free non-machinable deposit
- Improved crack resistivity
- Strong and rigid joint between cast iron parts
- Excellent color match to cast iron
- Preheating is recommended for heavy and complicated sections
- Ideal as a base layer to seal contaminations

**WELDING POSITION:**

WELDING POSITION :



AC (45 OCV)/ DCEP

**TYPICAL APPLICATIONS:**

- Welding of cast iron parts for all types of general
- reclamation or repair work
- Improved crack resistivity
- Ni free non-machinable deposit
- Strong and rigid joint between cast iron parts
- 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        | Mn   | Si       | S        | P        |
|---------------|----------|------|----------|----------|----------|
| Typical       | 0.1      | 0.5  | 0.1      | 0.03     | 0.03     |
| Specification | 0.15 max | 0.60 | 0.13 max | 0.04 max | 0.04 max |

**MECHANICAL PROPERTIES OF ALL WELD METAL:**

| Condition | Hardness (3 Layer), BHN |
|-----------|-------------------------|
| As Welded | 240-290                 |

**PARAMETERS- PACKING DATA:**

| Ø x L, mm  | Amperage,A | Wt./Carton kg | Carton/Bo x | Approx. wt. of 1000 pcs, Kg. |
|------------|------------|---------------|-------------|------------------------------|
| 3.15 x 350 | 55-75      | 2             | 5           | 10                           |
| 4.0 x 450  | 140-190    | 2             | 5           | 10                           |