

COVERED ELECTRODES FOR CAST IRON

DESCRIPTION & APPLICATIONS :

- SN-55 uses Iron-Ni alloy rod, the cast iron electrode of graphite series.
- High strength, toughness, cracking resistance, smaller coefficient of expansion, slight hardening, and easy to mechanical process.
- Use for nodular ductile cast iron, general cast iron maintenance, and hardening filling.

NOTE ON USAGE :

- According to the parent materials, formation, and dimension to preheat at 300°C and post heat treatment at 500~600°C afterwards, and finally room cooling.
- Proceed to hammer on each weld after the welding in order to reduce the shrinkage stress.
- Cast iron the poor ductility, it therefore the welding length is no more than 70mm for cracking protection on the edge of the joint due to high temperature.
- Welding more than two coatings the symmetrical welding on each coating should be taken by tack welding method in order to balance the heat on parent material, thermal stress, and cold surface balanced.
- Weld with a short arc and low current.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	Ni	Cr
0.70	0.70	0.75	55.0	0.05

SIZE AND RECOMMENDED CURRENT RANGE : AC or DC(+)

Diameter (mm)	2.6	3.2	4.0	5.0
Length (mm)	300	350	350	350
Current (Amp)	60-80	80-120	120-150	130-180