

COVERED ELECTRODES FOR CAST IRON

DESCRIPTION & APPLICATIONS :

- SN-99 use pure Ni-rod for the cast iron electrode of graphite series.
- Filler metal and cast iron is the smallest hardening at HAZ in cast iron electrodes, the best mechanical process.
- Use for diverse cast iron joints and repairing, for instance, cylinder cap, motor stand, and gear.

NOTE ON USAGE :

- No need preheat and post heat treatment but it depends on parent materials, formation, stress conditions that applies for post heat treatment at 150~200°C.
- 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
0.56	0.20	0.7	94.5

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	70-120	100-150	130-170