

ESSEN® Cast 99

AC/ DC +

Cast Iron electrodes For effective surface treatment

AWS A5.15-90 - CI; ASME SFA 5-15 A96 Eni - CI.

An Electrode for Joining Dissimilar Cast Iron & any Cast Iron to steels for Ultimate Strength & Superior Crack Resistance Properties.



PROPERTIES

This is a Nickel based electrode. Nickel, unlike iron, does not form carbides and has a low solubility for carbon. As the weld metal solidifies and cools, carbon is rejected from solution as graphite. This increases the volume of the weld metal, reducing shrinkage stresses and reducing the likely hood of cracking. The deposits are soft and machinable..

MECHANICAL PROPERTIES

Tensile strength : ~ 60,000 psi , Elongation : 4%

APPLICATIONS

This electrode is widely used to weld and repair cast irons, where machinability is required. Pumps, machine bodies, pump impellers, valves gear boxes can be welded very well. Most suitable for areas where very thin machinable built up is required like Neck Ring area of Pumps.

WELDING PROCEDURE.

Clean weld area of all oil, grease, etc. Preheat the area upto 2500 C. Use a close arc to control the heat input. Peen to relieve stresses. Allow to cool slowly.

RECOMMENDED AMPERAGE	
Size	Current
3.15mmx 350mm	090 - 110 Amps
4.00 mm x 350 mm	110 - 130 Amps

PACKING	
3.15 mm x 350 mm 5 kg	29 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	18 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

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ESSEN WELDING ALLOYS PVT. LTD. PUNE, INDIA,
TM REGISTERED IN INDIA BY: M/S. ASUGAR ENGINEERS PVT. LTD.
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