

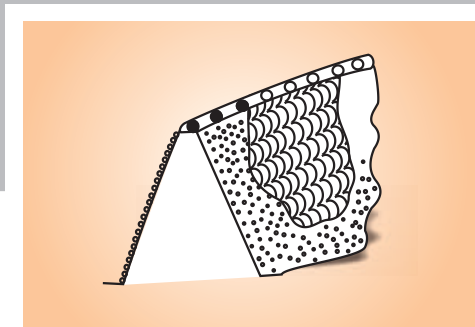
# ESSEN® NiCr8GS

AC/ DC +

## Cast Iron electrodes For effective surface treatment

### Special Product

A special electrode for Building up of broken super mill C I crusher roller tooth.



### PROPERTIES

The advantage of this electrode is its deposit free of porosity, machinable with carbide tip tool or grinding.

### MECHANICAL PROPERTIES

Tensile strength ~40,000 psi

### APPLICATIONS

Electrode for welding and overlaying cast iron, melted grey iron and nodular cast iron. For overlaying of tools in the automobile and ancillary industries, filling and recovery in the steel works of the ingot mould and guides and for build up of broken roller teeth of sugar mills.

### INDICATED BASE METAL

Grey iron, coarse and nodular cast iron.

### WELDING PROCEDURE.

As in all the welding, extent of cleanliness, preparation, skill of the welder, current setting affects the quality of welding, it is also true in this case. The base metal i.e. cast iron needs to be cleaned, free from oil, grease or chemicals. Use "ESSEN SUPER CUT" for preparation of weld surface. No preheating is required. Use stringent bead for lower heat input. Cool the surface between interpass. Deposits can be ground.

RECOMMENDED AMPERAGE	
Size	Current
2.50 mm x 350mm	065 - 075 Amps
3.15 mm x 350 mm	090 - 110 Amps
4.00mm x 350mm	110 - 130 Amps
5.00 mm x 350 mm	140 - 180 Amps

PACKING	
2.50 mm x 350 mm 5 kg	49 pcs/kg (Approx.)
3.15 mm x 350 mm 5 kg	26 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	20 pcs/kg (Approx.)
5.00 mm x 350 mm 5 kg	17 pcs/kg (Approx.)



**ESSEN**  
WELDING ALLOYS PVT. LTD.



**ESSEN & AZUCAR**  
PREMIUM WELDING ALLOYS

ESSEN® PRODUCTS ARE MANUFACTURED AND SUPPLIED  
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