

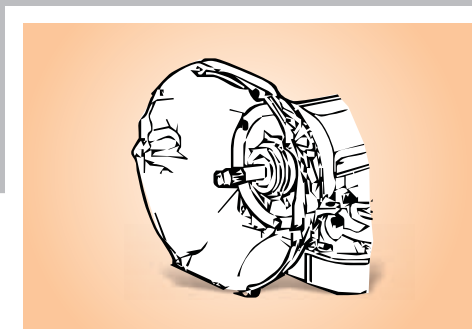
# ESSEN<sup>®</sup> Super Cast 188

AC/ DC +

Cast Iron electrodes For effective surface treatment

AWS A5.15 and ENi - C1

An Electrode for Brass Bronze & Copper and Joining These to Steel & Cast Iron.



## PROPERTIES

The ESSEN Super Cast 188 was developed using basic graphite as a covering, that permit to deposit a soft, uniform and nodular deposits which could be used in out of position welding (all position welding). The deposits are free of porosities, no inclusion of slag and no defects. Because it has base of pure nickel. The heat affected zone or transition zone are free of micro cracks. ...

## MECHANICAL PROPERTIES

Tensile Strength : 55,000 psi,                      Elongation : 4%

## APPLICATIONS

Special electrode for Nickel, nodular cast iron and for welding of Grey cast iron also for welding and joining of malleable iron. Used for superior penetration of contaminated areas.

## INDICATED BASE METAL

These electrodes are recommended for welding on cold cast iron, nodular and malleable cast iron and as a cushion layer on the contaminated casting with oil.

## WELDING PROCEDURE.

Clean the areas to be welded eliminating the rust, contaminations like grease and paint. In case of cracks, open the crack with ESSEN SUPER CUT. For good machinability avoid over heating of the job. The temperature between the passes should be kept as low as possible. Keep short arc and maximum length of the weld should be 10 times the diameter of the electrodes. Welding stresses can best be relieved with peening by ball peen hammer, each pass when it is in hot condition.

RECOMMENDED AMPERAGE	
Size	Current
3.15mmx 350mm	090 - 140 Amps
4.00 mm x 350 mm	120 - 190 Amps

PACKING	
3.15 mm x 350 mm 5 kg	23 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	20 pcs/kg (Approx.)



**ESSEN**  
WELDING ALLOYS PVT. LTD.



**ESSEN & AZUCAR**  
PREMIUM WELDING ALLOYS

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