

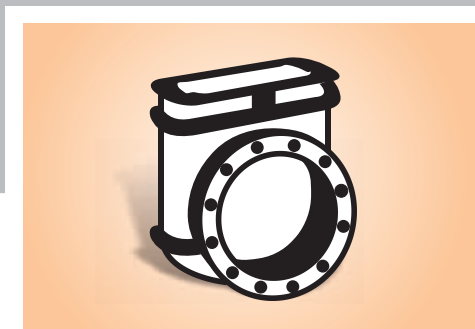
ESSEN® Cast GH

AC/ DC +

Cast Iron electrodes For effective surface treatment

AWS A5.15-90 EST

For Sealing Oil Soaked Cast Iron and Improving Weldability of Difficult Cast irons.



PROPERTIES

An economical steel cored electrode for high strength joining and overlaying for C-I. Deposits are non machinable, excellent colour match with C.I.

MECHANICAL PROPERTIES

APPLICATIONS

An electrode for welding of all types of C.I. where machining is not required. Excellent for welding on oil soaked, old and rusted C.I. as base or sealing layer prior to depositing machinable C.I. electrodes like ESSEN CAST 55 & ESSEN CAST 99. It also can be used for joining mild steel with C.I. when economy is the criteria for e.g. repair/ patch work of worn out coal pipes in power plants..

WELDING PROCEDURE.

Clean weld area. Prepare 'V' groove with the help of SUPER CUT so that the residual oil/grease will burn out. Use short arc for minimum heat input, direct the electrode on already deposited metal by slightly tilting the electrode in the direction of travel. Deposit short beads.

RECOMMENDED AMPERAGE	
Size	Current
3.15mm x 350mm	075 - 120 Amps
4.00 mm x 350 mm	105 - 140 Amps

PACKING	
3.15 mm x 350 mm 5 kg	34 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	21 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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