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| CATEGORY | SMAW Stick Electrodes | |
| TYPE | Low carbon Nickel free electrode for cast iron repairs | |
| APPLICATIONS | Cast iron parts, Nickel free for color matching grey cast Iron, malleable Cast iron and Nodular Cast iron. Repair of non invisible blow holes etc. | |
| PROPERTIES | Iron based electrode without Nickel | |
| CLASSIFICATION | AWS EN ISO | A 5.15: -E St 1071: E C St 1 |
| SUITABLE FOR | Cast iron parts, Nickel free for color matching Grey cast Iron, Malleable Cast iron and Nodular Cast iron. Repair of non invisible blow holes etc. | |
| APPROVALS | No Approvals Found | |
| WELDING POSITIONS: |  | |

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cu |
|------|-----|-----|-----|
| 0.15 | 0.1 | 0.5 | 0.1 |

ALL WELD MECHANICAL PROPERTIES

| Heat Treatment | R _{p0.2} MPa | R _m MPa | A ₅ (%) | Hardness Brinell Hardness |
|----------------|--------------------------|-----------------------|-----------------------|------------------------------|
| As Welded / | | | | Avg. 180 |

WELDING PARAMETERS / PACKING

| WELDING PARAMETERS | WELDING PARAMETERS | WELDING PARAMETERS | PACKING | PACKING | PACKING |
|--------------------|--------------------|----------------------|----------|------------|-----------|
| D (MM) | LENGTH (MM) | CURRENT (A) (AC/DC+) | KG / CAN | KG / 6PACK | KG / 1000 |
| 2.5 | 300 | 60-80 | | | |
| 3.2 | 350 | 90-110 | | | |
| 4.0 | 350 | 120-140 | | | |

REDRYING TEMPERATURE 140°C / 2 hr

GAS ACCORDING EN 14175