

Standards

TS 9463 EN ISO 1071	: E C Fe-2
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Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	V
0.07	1.0	0.8	8.0

Mechanical Properties

Weld Metal Hardness (HB)
~ 250

Features and Applications

- Repair of welding defects, for facing of worn-out parts of mold of automobile body, shielding process of metal frictioning works
- Good results at joint welding of steel with cast iron
- Basic coated, Barium compound free, iron base, Vanadium alloyed cast iron electrode, which is used for repairing and maintenance of defective lamellar and nodular cast iron equipment and machine parts. Also used for hard face welding of wear susceptible of cast iron parts
- Advantages of this Nickel free cast iron electrode is;
- The deposit metal is a close color match to cast iron,
- The similarity of chemical composition of weld metal and cast iron assures similar that expansion and contraction characteristics, as a result there is no subject about thermal deformation
- When welding, electrode is not hot, as a result welding can be done uninterrupted and more quickly

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101725	2.50 x 350	3/32 x 1 4"	70 - 100	2270
3010101732	3.20 x 350	1/8 x 14"	100 - 120	3650
3010101739	4.00 x 350	5/32 x 14"	120 - 160	5260

Approvals: CE, SEPRO, TSE