

GEECOR 505

TUBULAR ELECTRODE FOR JOINING AND SURFACING OF HIGH STRENGTH GRADES OF CAST IRON.

IDENTIFICATION

Geecor 505

DESCRIPTION

Low heat in-put machinable cast iron electrode for joining and surfacing of all grades of cast irons.

MECHANICAL PROPERTIES (RANGE)

UTS (kg/mm2)	EL (%) (L=4D)
52	18

TYPICAL APPLICATIONS

Filling cavities in the cast irons, correcting machining errors by depositing weld metal, joining, repair and surfacing of high strength grades of cast-iron.

SALIENT FEATURES OF THE ELECTRODES

- A tubular electrode with special flux having no Barium compounds conforming to AWS/SFA 5.15 ENiFeMn - CI.
- Contains 10 to 14% Mn in Nickel - Iron system.
- Properties closer to high strength grades of cast-iron.
- Lower co-efficient of thermal expansion.
- Higher hot-cracking resistance.
- High metal recovery 75 to 80% approx.
- High deposition rate, non-hygroscopic coating, no pre-drying and longer shelf-life.
- Deposit is machinable and crack-proof.
- Weld deposit has higher tensile strength & elongation compared to equivalent to solid core electrode.
- Sound weld metal & good bonding on cast iron in cold condition. Specially suitable for SG, Malleable cast iron. Ideal for joining casting with steel & also surfacing.

PACKING PARAMETERS

Diameter (mm)	Length (mm)	AMPS AC (70 OCV) / DC (+)	Packing / Box (kg)
6.3	450	75 - 130	5 x 4 = 20
8	450	110 - 160	5 x 4 = 20