

GRICAST CN

IDENTIFICATION

Gricast CN, ENi-Cu-B

CLASSIFICATION

AWS/SFA 5.15: ENi-Cu-B

DESCRIPTION

Monel based, extruded electrodes for cold welding for cast iron. Weldable in all positions. It has a soft and stable arc having good striking and restriking properties. The weld metal including the heat affected zone is easily machinable.

WELD METAL ANALYSIS (RANGE) %

C	Ni	Cu	S	Mn	Fe	Si
0.35 - 0.55	60.0 - 70.0	25.0 - 35.0	0.025	2.30 max	3.0 - 6.0	0.75 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	Hardness
280 - 390	140 - 190 Brinell

TYPICAL APPLICATIONS

Joining, repairing and surfacing of all types of cast iron without pre-heating of the parent metal.

WELDING INSTRUCTIONS

- For building up the part, the electrode should be connected to D.C. + polarity to reduce the transfer of heat to the work piece.
- To obtain flat bead the electrode is to be connected to D.C. polarity.
- By using A.C., the effect will be in between the aforementioned D.C. conditions, pre-heating of the parent metal is not necessary.

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS AC / DC (+)	Packing / Box (kg)
2.5	350	50 - 80	2 x 5 = 10
3.15 / 3.20	350	70 - 110	2 x 5 = 10
4	350	90 - 130	2 x 5 = 10
5	350	120 -160	2 x 5 = 10