



## Monel Alloy Electrode for Cast Iron Repair and Welding

CLASSIFICATION : AWS A/SFA 5.15

E NiCu-B

### KEY FEATURES :

- Graphite based coating
- Monel type weld deposit
- Machinable weld
- Minimum dilution ensures shallow but sufficient depth of fusion
- No need of preheating

WELDING POSITION : 



AC (45 OCV)/ DCEP

### TYPICAL APPLICATIONS :

- Repair of cast iron castings
- Well suited for Gears, machinery parts, Pump bodies
- Rebuilding worn surfaces
- Joining cast iron to steel
- Correcting machining errors on castings

REDRYING CONDITION : 150°C for 1 hr. (Also available in vacuum packed condition)

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Ni	Fe	Mn	Si	S	Cu
Typical	0.4	65.0	4.2	1.6	0.4	0.01	Bal.
Specification	0.35-0.55	60.0-70.0	3.0-6.0	2.30 max	0.75 max	0.025 max	Bal.

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	Hardness(3 Layer), BHN
Specification	As Welded	200 max

### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg
2.5 x 300	45-60	1	10	10
3.15 x 300	90-110	1	10	10
4.0 x 300	120-150	1	10	10