

REPTec CAST 3

MMA (SMAW)

REPAIR ELECTRODE

PRODUCT DESCRIPTION

Basic graphite coated stick electrode with nickel iron core for cold welding of cast iron, malleable cast iron and joint welding to steel

Specially developed for good peen- and machinable seams e.g. for thick joints

In order to introduce as little heat into the work piece as possible, it is advisable to weld with DC positive

CLASSIFICATIONS

AWS A5.15	ENiFe-CI
ISO 1071	E C NiFe-CI 1

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PG/3Gd



PE/4G

CURRENT TYPE

AC/DC +

CHEMICAL COMPOSITION (WIRE WT %)

	C	Fe	Ni
Min.	--	--	45.0
Max.	2.0	--	60.0
Typical	0.6	40	bal.

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.15	ISO 1071	Typical
Tensile strength (MPa)	400-579	350	460
0.2% proof strength (MPa)	296-434	250	300
Elongation (%)	6-18	6	20
Hardness HB10	165-218	--	175

TYPICAL OPERATING PARAMETERS, DC +VE OR AC (OCV: 50V MIN)

Diameter (mm)	2.5	3.2	4.0
min. A	50	70	90
max. A	100	90	120

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	carton	pack	carton
PE TUBE	2.5	300	401035	155	155	2.5	2.5
	3.2	300	401042	95	95	2.5	2.5
	4.0	350	401059	54	54	2.5	2.5