

# CASTEN

## CLASSIFICATIONS

**AWS A/SFA 5.15** ESt

**IS 5511** E Fe B26

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

A low hydrogen type electrode for non-machinable welds on cast iron. The electrode should be preferred when a strong and rigid joint is to be obtained between two cast iron parts. The electrode operates in all positions except vertical down. Pre-heating is recommended for heavy and complicated sections.

## TYPICAL APPLICATIONS

Welding of cast iron parts for all types of general reclamation or repair work, where machinability is not a primary concern. Joining cast iron to mild steel, etc.

## APPROVALS

**RDSO** Class F

**CURRENT CONDITIONS:** AC, DC

5.0	4.0	3.2	2.5
190-250	140-190	100-140	60-90

## WELDING POSITIONS

F & H Fillet

## REDRYING CONDITIONS

250°C for 1 hour (Optionally also available in vacuum-packed condition)

### WELD METAL CHEMISTRY, (%)

C - 0.15	max.	Fe -	Rem.
Si - 0.15	max.	S -	0.04 max.
Mn - 0.30-0.60	max.	P -	0.04 max.

### PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	450	450	450	350
Wt. per carton, kg	5	5	5	5
Cartons / box	4	4	4	4
Net wt per box, kg	20	20	20	20



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