

CASTMONEL

CLASSIFICATIONS

AWS A/SFA 5.15 ENiCu-B

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode with monel core wire and graphite-based coating for welding cast iron without preheating and for obtaining a machinable weld. The arc is soft and stable with least spatter. The thin slag is easily detachable. The electrode gives an extremely shallow and yet sufficient depth of fusion, which ensures minimum dilution of the weld metal by the base metal. The weld deposit gives as welded hardness, below 200BHN. To further ensure minimum hardness, the arc during welding should be directed on the weld puddle and not on the base metal.

TYPICAL APPLICATIONS

Repair of cast iron castings, Machining errors on castings, Rebuilding worn surface, Joining cast iron to steel, Well suited for gears, Machinery parts, Pump bodies etc.

CURRENT CONDITIONS: AC, DC

4.0	3.2	2.5
120-150	90-110	45-60

WELDING POSITIONS

F & H Fillet

REDRYING CONDITIONS

150°C for 1 hour
(Optionally also available in vacuum-packed condition.)

WELD METAL CHEMISTRY, (%)

C	- 0.35-0.55	Fe	- 3-6
Ni	- 60.0-70.0	S	- 0.025 max.
Cu	- Balance	Si	- 0.75 max.
		Mn	- 2.3 max.

PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	300	300	300
Wt. per carton, kg	1	1	1
Cartons / box	10	10	10
Net wt per box, kg	10	10	10



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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