



## RASI CI - MONEL

### CAST IRON WELDING ELECTRODES

#### TECHNICAL SPECIFICATION SHEET

#### CAST IRON ELECTRODE

RASI - CI - MONEL

CAST IRON ELECTRODE WITH M/C DEPOSIT

#### CLASSIFICATIONS

AWS / SFA E Ni - Cu - B

#### CHARACTERISTICS

RASI - CI - MONEL is a Medium graphite coated Monel core wire, specially designed for Machinable welding.

#### APPLICATIONS

RASI - CI- MONEL is used for welding cast iron where the best colour match is required. Welding of pump bodies, gears, machinery parts. Cast iron to steels joining. Rectification of defective castings.

#### SUGGESTED WELDING PROCEDURE

Use short arc and stringer bead not longer than 70mm. Peen each bead and remove slag thoroughly for stress relieve. Ensure the welding not to hot the base metal.

#### CHEMICAL COMPOSITION OF ALL WELD METAL

ELEMENT	C	Fe	Ni	S	P	Cu
PERCENTAGE	0.6-1.2	0.5-2.5	60-70	0.03	0.03	Balance

Note: Single Values shown above are maximum

#### MECHANICAL PROPERTIES OF ALL WELD METAL

U.T.S. Kgf/mm <sup>2</sup>	UTS N/mm <sup>2</sup>	Hardness
25-40	250-400	200-300 BHN

#### WELDING CURRENT : AC 70 V / DC(+)

Dia (mm)	2.5 x 350	3.15 x 350	4 x 350	5 x 350
Current (A)	50-70	70-100	100-120	140-150

PACKING : 1 Kg/pkt x 12 pkts = 12 kgs/Box

storage - Store in warm and dry place. If damp re dry at 100-110°C for 30 minutes.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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