

**CAST IRON WELDING
 ELECTRODES**

TECHNICAL SPECIFICATION SHEET

CAST IRON ELECTRODE

RASI - CI - FN
 MACHINABLE DEPOSIT

CLASSIFICATIONS

AWS / SFA E Ni-Fe-CI

CHARACTERISTICS

RASI - CI - FN is a Medium coated Ferro - nickel core wire for specially designed for welding of known and unknown cast iron base metal, the Ni deposit does not pick up C from the base Metal.

APPLICATIONS

RASI - CI - FN is used for
 Welding of all types of cast irons (i.e) Nodular, malleable cast iron.
 Cast iron to mild 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 |
|---------|-----|---------|-------|------|------|
| % (MAX) | 1-2 | Balance | 40-60 | 0.03 | 0.03 |

MECHANICAL PROPERTIES OF ALL WELD METAL

| U.T.S. Kgf/mm ² | UTS N/mm ² | Hardness |
|----------------------------|-----------------------|-------------|
| 35-45 | 330-440 | 125-175 BHN |

Note: Single Values shown above are maximum

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 damped 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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