

**SMAW**

For Cast Iron

**CASTARC 150N**

CLASSIFICATION : AWS A5.15 ENiFe-CI

JIS Z3252 DFCNiFe

WELDING POSITIONS :



- Basic, Graphite Coating
- Machinable Nickel-Iron Weld Deposit

**DESCRIPTION AND APPLICATIONS**

CASTARC 150N is a high grade special purpose electrode with ferro - nickel alloy core rod (Fe 45% Ni 55%). This electrode weld deposits gives extra strength and machineability. CASTARC 150N features an extremely soft, smooth arc action with low spatter and minimal penetration on either AC or DC. Suitable for welding of nodular cast iron, repairing and joining all kinds of cast iron. Also suitable for underlaying of hardfacing.

**TYPICAL ALL WELD METAL COMPOSITION (Wt%)**

C	Mn	Si	P	S	Fe	Ni
1.26	0.80	0.66	0.005	0.003	Bal	57.25

**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•**

TENSILE STRENGTH	ROCKWELL
500 N/mm <sup>2</sup>	HrB 85 - 95

- in "as welded" condition.

**OPERATIONAL AND PACKAGING DATA**

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE • (amps)	PACKAGING (kg)		
			PKT	CTN	
2.6	300	50 - 75	1	2.5	20
3.2	350	60 - 100	1	2.5	20
4.0	350	90 - 130	1	2.5	20

- Recommended for DC + or AC (minimum 45 OCV) operation

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