

SMAW

For Cast Iron

CASTARC 50N

CLASSIFICATION : JIS Z3252 DFCFe

WELDING POSITIONS :

**DESCRIPTION AND APPLICATIONS**

CASTARC 50N is a graphite electrode using mild steel rods. Its weld metal shows high carbon content. Then it results high hardness, so it is suitable for welding the parts where machining is unnecessary. Its fusibility with cast iron is excellent.

TYPICAL ALL WELD METAL COMPOSITION (Wt%)

C	Mn	Si	P	S	Fe	Ni
0.95	0.33	0.11	0.014	0.015	Bal	57.25

OPERATIONAL AND PACKAGING DATA

ELECTRODE SIZE (mm)	ELECTRODE LENGTH (mm)	WELDING CURRENT RANGE * (amps)	PACKAGING (kg)		
			PKT	CTN	
2.6	300	50 - 90	1	2.5	20
3.2	350	90 - 120	1	2.5	20

Recommended for DC + or AC (minimum 60V OCV) operation

INSTRUCTIONS FOR WELDING

The preheat temperature vary in accordance with kind, shape and size of base metal. Preheating over 200°C is appropriate to prevent cracking, slow cooling is recommended after welding.

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