

Ratna Cast Fn

CLASSIFICATION

- AWS/SFA-5.15 E NI FE CI
- DIN E NIFEG3

APPLICATIONS

- Suitable to weld and repair all types of cast Iron components.
- Broken casting, joining cast iron to steel.
- Cast iron components subjected to wear and tear etc.
- Suitable for underplaying of hard facing.

DESCRIPTION

- A medium coated, ferro-nickel core wire electrodes specially designed to weld cast iron components in cold conditions. The deposit is soft and machinable, retains strength, enable to weld large cast iron castings, produces crack free joints.

TYPICAL WELD METAL CHEMICAL PROPERTIES (ELEMENT %)				
CARBON (C)	MAGNESIUM (MN)	SILICON (SI)	NICKEL (NI)	IRON (FE)
0.80-2.00 MAX	1.00 MAX	1.00 MAX	50.0 MIN	BAL

CURRENT POLARITY	WELDING POSITION
DC(+), AC	FLAT, HORIZONTAL-FLAT

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)
HARDNESS (VPN)
170-190

SIZE AND CURRENT RECOMMENDATIONS		
SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
2.5mm x 350mm	3/32" x 14"	50-70
3.2mm x 350mm	1/8" x 14"	80-100
4.0mm x 350mm	5/32" x 14"	110-140

WELDING PRECAUTION

- Clean the weld area free of any surface contaminations.
- Preheating of the job between 250°C – 500°C may be necessary according to the amount of weld metal to be deposited and the size and type of casting.
- After the welding is completely with a layer of asbestos or dry lime until it attains room temperature.

RE-DRY CONDITIONS

- Re-dry the electrode at 150°C for 1 hour.

NOTE:
THE INFORMATION PROVIDED IN THIS ARTICLE OR OTHERWISE REFERRED TO HEREIN IS MERELY PROVIDED AS "TYPICAL" WITHOUT ANY ASSURANCE OR PROMISE. ACTUAL RESULTS WILL VARY BASED ON A NUMBER OF VARIABLES, INCLUDING, BUT NOT LIMITED TO, WELD PROCESS, PLATE CHEMISTRY AND TEMPERATURE, WELDMENT DESIGN, AND FABRICATION PROCEDURES. WASHINGTON CENTRAL CORPORATION EXPRESSLY DISCLAIMS ANY LIABILITY SUFFERED FROM ANY RELIANCE THEREON. IT IS ADVISED THAT BEFORE USING ANY WELDING CONSUMABLE OR PROCEDURE IN THE INTENDED APPLICATION, USERS CHECK THEIR COMPATIBILITY THROUGH QUALIFICATION TESTING OR OTHER SUITABLE METHODS.