

# SUNWELD MONEL

Cast Iron Electrode



## CLASSIFICATION

AWS/A 5.1 : E Ni Cu B

## CHARACTERISTICS

An electrode with Ni-Cu alloy wire specially designed for the welding of Cast Iron parts. The weld metal easily bonds and strongly with the cast iron. Multi pass welding can be done. The weld metal is free from cracks and has best color match with parent metal.

## APPLICATIONS

Machine bases, engine blocks, pumps and transmission houses, repair of gears, joining of cast iron to steel as well as non-ferrous materials.

## CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Nickel	Copper
0.42	1.2	0.42	64.2	33.76

**HARDNESS:** Three layer deposit 200 BHN Max

## CURRENT RANGE & PACKING DATA:

Size (mm)	Length (mm)	Current(Amp) AC or DC(+)	Quantity of Electrodes in a Carton	Quantity of Electrodes in a Cardboard box
2.50	350	50-70	2 Kg	10 Kg
3.15	350	70-100	2 Kg	10 Kg
4.00	350	100-130	2 Kg	10 Kg
5.00	350	130-170	2 Kg	10 Kg

## RECOMMENDATIONS:

Preheat of job to 100°C will give good results. Use stringer beads and lowest possible amperage with back step sequence. Peen the weld bead after every 2-3 inches of welding. Avoid overheating of job.