

CLASSIFICATION

AWS/A 5.1 : EST

CHARACTERISTICS

SUNWELD NM is a unique electrode with mild steel core wire which deposits grey Cast Iron. Suitable for welding of grey cast iron. Parent metal and weld metal matches absolutely. Hence there are no differential stresses and thus no cracking after cooling. Preheat is a must and varies from 450°C to 760° depending upon the size of the job.

APPLICATIONS

Joining of grey cast iron, welding of cast iron to steels.

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
2.42	0.40	5.4	0.19	0.10

HARDNESS: 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	60-90	2 Kg	10 Kg
3.15	350	110-330	2 Kg	10 Kg
4.00	350	140-170	2 Kg	10 Kg

RECOMMENDATIONS:

Temperature of the job should remain constant until welding is completed. Cool the welded piece under insulation with very slow cooling rate.