

## CAST MONEL

**Monel alloy electrode for welding of cast Iron Machinable welds. .**

**CLASSIFICATION** : AWS/SFA-5.15: E Ni Cu B  
DIN E NiCuG3

**APPROVAL** :

**CHARACTERISTICS** : A light basic coated graphite based electrode for cold welding. Weld deposit is monel (Nickel-Copper) type, easy to weld and can be used on components without pre heating for achieving machinable weld deposit.

**APPLICATION** :

- 1) Suitable to weld carbon steel to cast iron.
- 2) Broken casting repairs.
- 3) Machining defect rectification, filling up castings.
- 4) Rebuilding worn out surfaces.
- 5) Machine bases, Engine blocks, gears, pumps etc.

**RE-DRY CONDITION** : Re-Dry the electrode at 150° for 1 hour.

**WELDING PRECUATIONS** :

1. clean the weld area free of any surface contaminations.
2. In case of repair welding on casting, remove entire defective portion prior to welding.
3. Use the short arc and as possible as low current.
4. preheat the part, if necessary.

**ALL WELD CHEMICAL COMPOSITION %**

| C         | Mn       | Si       | Ni          | Cu          | Fe       |
|-----------|----------|----------|-------------|-------------|----------|
| 0.35-0.55 | 1.00 Max | 0.75 max | 60.00-70.00 | 25.00-35.00 | 3.00 Max |

**WELD METAL HARDNESS:**

| Hardness    |
|-------------|
| 140-170 VPN |

**DIEMENSION, CURRENT CONDITION & PACKING DATA**

| Size(mm)<br>(Dia) | Size(inch)<br>(Dia) | Current Condition<br>(DC+/ AC) Amps | Wt. of /pkt. | Wt. of Case |
|-------------------|---------------------|-------------------------------------|--------------|-------------|
| 2.50/ 2.40 X 350  | 3/ 32" X 14"        | 60-80                               | 2            | 20          |
| 3.15/ 3.20 X 350  | 1/ 8" X 14"         | 80-110                              | 2            | 20          |
| 4.00 X 350        | 5/ 32" X 14"        | 110-130                             | 2            | 20          |
| 5.00 X 350        | 3/ 16" X 14"        | 130-180                             | 2            | 20          |

Customer packing on request.