

Classifications

AWS A5.15

Est

Characteristics and field of use

Basic low hydrogen steel electrode alloyed with Nickel for build-up of grey cast iron. The application is for buffer layer of cast iron before hard facing.

Typical analysis of all weld metal (Wt.-%)

C	Si	Mn	Cr	Ni	Fe	
< 0.1	0.5	1.0	4.5	13	Balance	

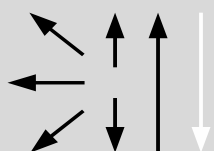
Mechanical properties of the weld metal

Hardness	Hardness	
HRC	HRB	
25 - 35	300 - 350	

Welding Instruction

Clean welding area. Pre-heating of thick wall part to 150°C - 250°C. Hold the stick electrode vertically with short arc. Re-dry stick electrode before use at 300 - 350°C at 2 hrs.

Welding Position



Current type DC (-) / AC

Size, Packing and Recommended welding parameters

Size (mm)	Kg / Pack	Kg / Box	Amperage (A)
2.50 x 350	5.0	20.0	60 - 90
3.25 x 350	5.0	20.0	100 - 140
4.00 x 350	5.0	20.0	140 - 190
5.00 x 450	6.2	24.8	180 - 230