

+ Orange - Cast General - NMCA (AWS Spec. ●)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm ²	UTS N./mm ²	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	●	●	●	●	●	●	●	585-615		●	●

Application:

Welding Cast Iron Parts (Non-Machinable), Building up machine frames, repair of foundry casting, Gear boxes, Differential housing, sugar mills rollers, Cast Iron dies.

+ Orange - Cast - MCA (AWS Spec. E NiFe CI)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm ²	UTS N./mm ²	Elongation % L = 4D	Impact / Joules	Testing Temp
1.50	0.50	2.50	0.03	0.03	●	55.0	●	2.50	Bal	●	400-510	177 (BHN) Approx		●

Application:

Welding Cast Iron Parts (Machinable), Heavy foundry casting, Automobile engine blocks and heavy casting machinery parts, can be used of Casting containing phosphorus level higher than normal upto 0.2%

+ Orange - Monel (AWS Spec. E NiCu B)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm ²	UTS N./mm ²	Elongation % L = 4D	Impact / Joules	Testing Temp
0.80	1.00	0.60	0.03	0.03	●	65.0	●	Bal	2.0	●	280-400	140-160 (BHN)		●

Application:

Welding for fracture and heavy castings, Fabricating Cast Iron machine components, Rebuilding worn-out surfaces.

+ Orange - Nicron (AWS Spec. E NiCr)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm ²	UTS N./mm ²	Elongation % L = 4D	Impact / Joules	Testing Temp
1.20	1.00	0.60	0.03	0.03	●	96.0	●	●	Bal	●	280-350	150 BHN Approx		●

Application:

Because of Easy and Intimate fusion with all grades of cast iron, the electrode is best suited for Engine components, Gear Wheels, Sprockets and joining Cast Iron to Steel.

+ Orange - Bronze (AWS Spec. E CgSn A)

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %	Fe %	Y.S N./ mm ²	UTS N./mm ²	Elongation % L = 4D	Impact / Joules	Testing Temp
●	●	●	●	0.03	●	●	●	92-96	Sn 4%	●	●	●		●

Application:

Welding of Copper or Bronze to Cast Iron or Steel where a machinable veld as required. Also can be used in ships, Propeller bearings, Bushings, Impeller blades, Valve steels, Brass, Galvanized Iron, Mild Steel Phosphorus Bronze & Brass