

## CASTCRAFT 100

45  
OCVAC  
DC+

- ▲ Maintenance Welding of Cast Irons.
- ▲ Lime Fluorspar / Graphite Coating.
- ▲ Soft, Ductile Nickel Deposit.
- ▲ Easy starting and Stable Running on Portable 240V Welding Machines.
- ▲ Smoother Weld Deposit Surface Finish.

## Classifications:

AWS/ASME-SFA A5.15: ENi-CI.

## Description and Applications:

Castcraft 100 is a basic, graphite coated electrode manufactured by CIGWELD for the repair and maintenance of a wide range of cast iron components.

It produces a soft stable arc with minimal penetration and spatter and is very tolerant to parent metal contaminants such as oil and dirt. The ductile Nickel based weld deposit is readily machinable with good colour match to most cast irons.

Applications of Castcraft 100 include the repair and reclamation of engine blocks, cylinder heads, differential housings, gear boxes, pump and machine housings and cast iron pulleys etc. In some applications Castcraft 100 is preferred to Castcraft 55 because of the better 'wetting' action of the high nickel weld deposit.

## Procedure for Welding Oil Contaminated Cast Iron:

For welding oil impregnated cast iron an increased arc length of up to  $\approx 6$ mm is recommended to reduce the porosity in the weld deposit (caused by the oil) to an acceptable level. For heavy oil contamination, preheating the cast iron up to 200°C will also help to reduce porosity levels.

## Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC- polarity.

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Easyweld Handipaks	Part No
2.5	300	49	55-85	2.5kg	15kg - 6 x 2.5kg		611732
						20 rod	322110
3.2	350	31	75-120	2.5kg	15kg - 6 x 2.5kg		611733
						15 rod	322111

## Easyweld Blister Pack:

10 x 2.5mm/5 x 3.2mm rod Castcraft 100 Blister Pack

322217

## CORE WIRE:

Nickel (98% Ni)

## TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Tensile Strength	400 MPa
Hardness	170 HV <sub>30</sub>

## TYPICAL ALL WELD METAL ANALYSIS:

C: 1.0%	Mn: 0.05%	Fe: 0.5%
Si: 0.1%	Al: 0.2%	Ni: Bal



All downhand welding