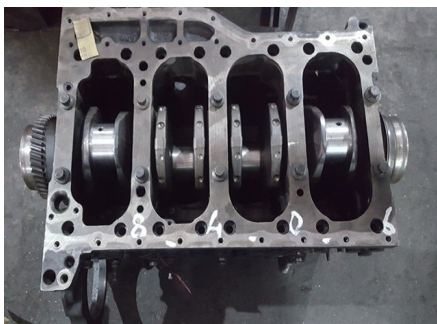


CAST IRON-WELDING –REPAIR -SOLUTIONS –PRODUCTS (2)

PRODUCT GOLD ARCWEL	DESCRIPTIONS	TECHNICAL DETAILS	Ø mm	APPLICATIONS
410 SMAW (606)	Universal Electrode for cold repair welding of most different types of cast iron. Excellent machinability. Weld metal composition : Ni > 95 , Fe, Mn, C, Si	Rm (Mpa) : 350 Hardness : ~180 HB	2.5 3.2 4.0	Use for welding and rebuilding of frames, gear box, machine and pump housings, engine blocks, casting defects,
420- SMAW (601)	High strength Fe Ni Alloy electrode for cold welding of different Cast irons such as grey cast iron nodular cast iron and for joining cast iron to steel. Electrode will not overheat and has exceptional good mechanical properties. Can also be used as a bonding layer on dirty or oily cast iron. Weld metal composition :Ni, Fe, Mn, C, Si	Rm (Mpa) : 550 Re (Mpa) : 350 A5 (%) : 15 Hardness : 200—220 HB	2.5 3.2 4.0	For Base Metals: Grey cast iron ASTM A48 class 25 B-60 B, A536 Grade 60-80 DIN GG15-GG40, GGG 40 to 60, GTS 35 to 65
707 (SMAW) (605)	Economy type Nickel base Electrode for repair and fabrication of cast iron components. Recommended for welding gray, nodular and malleable cast iron and for joining cast iron to steel. GOLD 707 is one of the <u>most economic electrodes</u> for welding of cast-iron.	Rm (Mpa) : 420 Re (Mpa) : 350 A5 (%) : 15 Hardness :	2.5 3.2 4.0	Engine blocks, casting defects, Pulleys, Compressors Pump housings
715 (SMAW) (603)	Special iron based electrode for repair welding of poor quality, slag or oil containing old cast iron (furnace part, boxes, heaters, pumps,...) Also used for hard facing of cast iron press tools and dies (automotive)	Hardness : ~ 350 HB	2.5 3.2 4.0	Use as a first layer (buttering layer) on difficult to weld cast iron.



For Engine Blocks



For Cylinder Heads



For Pump Housings