

**CASTCRAFT 100**
**45  
OCV**
**DC**

- Maintenance Welding of Cast Irons
- Lime Fluorspar/ Graphite Coating.
- Soft, Ductile Nickel Deposit.
- Easy Starting and Stable Running on Portable 240V Welding Machines
- Ideal for Repair & Maintenance Jobs
- Smoother Weld Deposit Surface
- Packed in Resalable Plastic Tubes

**TYPICAL ALL WELD METAL ANALYSIS:**

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

**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

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

**CORE WIRE:**

Nickel (98% Ni)

**Classifications:**

ISO AS/NZS 1071: E C Ni- CI 3  
 AWS/ASME-SFA A5.15: ENi-CI.

**Description and Applications:**

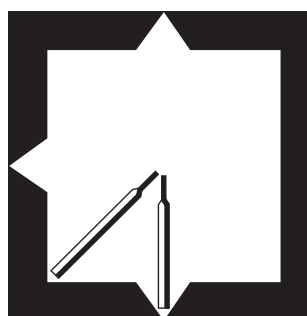
Castcraft 100 is a basic, graphite coated electrode manufactured by CIGWELD for the repair and maintenance of a wide range of cast iron components.

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 ~ 6mm 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.



All downhand welding

**Packaging and Operating Data:**

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

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
2.5	300	61	55-115	2.0kg	12kg – 6 x 2.0kg	611732N
3.2	350	32	80-140	2.2kg	13.2kg – 6 x 2.2kg	611733N
4.0	350	21	100-190	5kg	15kg – 3 x 5kg	611734N