

CIGWELD

AN **ESAB** BRAND

WeldSkill

CAST2STEEL

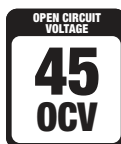
“ *WeldSkill Electrode handy-packs for all of your smaller projects* ”

FEATURES

- Maintenance Welding of S.G. Cast Irons
- Joins Cast Iron to Steel
- Lime Fluorspar / Graphite Coating
- Higher Strength Nickel / Iron Deposit
- Easy starting and stable running on portable 240V Welding Machines



📱 🌐 📺 📺 | CIGWELD.COM.AU



WELDSKILL CAST2STEEL

WELDSKILL CAST2STEEL is a basic, graphite coated Nickel / Iron electrode manufactured by CIGWELD for the higher strength repair and maintenance welding of Spheroidal Graphite (S.G.) irons, austenitic cast irons, meehanites and a wide range of grey cast irons. 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 / Iron weld deposit is machinable with the higher strength required for welding S.G. irons. Where higher joint strength is

important, WELDSKILL CAST2STEEL may be used for root and fill passes followed by capping passes with Castcraft 100 for a smoother surface finish.

Procedure for Welding Oil Contaminated Cast Iron:

For welding oil impregnated cast iron an increased arc length of up to $\approx 6\text{mm}$ 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.

CLASSIFICATIONS

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

CORE WIRE

Nickel Iron (55% Ni, 45% Fe)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES

Tensile Strength 500 MPa
Hardness 220 HV₃₀

TYPICAL ALL WELD METAL ANALYSIS

C:	Mn:	Si:	Al:	Ni:	Fe:
0.95%	0.65%	0.25%	0.25%	53%	Bal

FEATURES

WeldSkill CAST2STEEL Welding Electrodes

- Maintenance Welding of S.G. Cast Irons.
- Joins Cast Iron to Steel.
- Lime Fluorspar / Graphite Coating.
- Higher Strength Nickel / Iron Deposit.
- Easy starting and stable running on portable 240V Welding Machines.

ORDERING INFO

Part No.	Size	Pack Size	Carton
WEC0225	2.5mm	10 rods	20 x 10 rods
WEC1025	2.5mm	1kg	12kg - 12 x 1kg
WEC0232	3.2mm	10 rods	20 x 10 rods
WEC1032	3.2mm	1kg	12kg - 12 x 1kg



All downhand welding



CIGWELD Pty Ltd An ESAB Brand 71 Gower Street, Preston VIC 3072 Australia
Customer Care: Tel: 1300 654 674, Fax: 03 9474 7391, Email: enquiries@cigweld.com.au
International Enquiries: Tel: +61 3 9474 7508 Fax: +61 3 9474 7488



CIGWELD.COM.AU

In the interest of continuous improvements, CIGWELD Pty Ltd ABN 56 007 226 815 (An ESAB Brand) reserves the right to change specifications or design on any of its products without prior notice.

WE RECOMMEND GENUINE CIGWELD PRODUCTS

BIGGEST RANGE, BEST QUALITY & GUARANTEED PERFORMANCE

