

CIGWELD

AN ESAB BRAND

STICK

CASTCRAFT 100

PRODUCT DATA SHEET



BASIC, GRAPHITE COATED ELECTRODE

45
OCV

DC

STAINLESS STEEL AND SPECIAL ELECTRODES

CASTCRAFT 100

- 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 Finish.
- Packed in Resealable Plastic Tubes.

CLASSIFICATIONS:

ISO AS/NZS: 1071

E C NI- CI 3

AWS/ASME-SFA A5.15:

ENi-CI

CORE WIRE:

Nickel (98% Ni)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Tensile Strength	400 MPa
Hardness	170 HV ₃₀

TYPICAL ALL WELD METAL ANALYSIS:

C:	1.0%
Mn:	0.05%
Fe:	0.5%
Si:	0.1%
Ai:	0.2%
Ni:	Balance

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 $\approx 6\text{mm}$ 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.

PACKAGING & OPERATING DATA:

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

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACK SIZE	CARTON	PART NO.
2.5	300	61	55-115	2kg	12kg - 6 x 2kg	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

WELDING POSITIONS:

All downhand welding.

