

CIGWELD

AN ESAB BRAND

BLUESTRIKE

BLUSTRIKE CASTCRAFT

PRODUCT DATA SHEET



BLUESTRIKE ELECTRODE HANDY-PACKS FOR ALL OF YOUR SMALLER PROJECTS



AC
DC-

45
OCV

CAST IRON

BLUESTRIKE CASTCRAFT:

BlueStrike CASTCRAFT 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, BlueStrike CASTCRAFT 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.

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

CLASSIFICATIONS:

AWS/ASME-SFA A5.15:

ENiFe-CI.

CORE WIRE:

Nickel Iron (55% Ni, 45% Fe)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

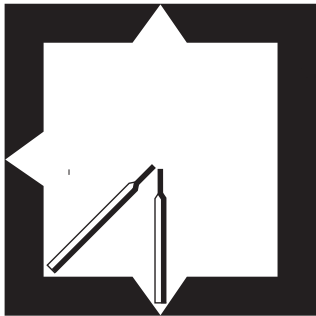
Tensile Strength	500 MPa
Hardness	220 HV ₃₀

TYPICAL ALL WELD METAL ANALYSIS:

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

WELDING POSITIONS:

All downhand welding



ORDERING INFO:

PART NO.	SIZE PACK	SIZE	CARTON
WEC0225	BlueStrike CASTCRAFT Electrodes 2.5mm	10 rods	20 x 10 rods
WEC1025	BlueStrike CASTCRAFT Electrodes 2.5mm	1kg	12kg - 12 x 1kg
WEC0232	BlueStrike CASTCRAFT Electrodes 3.2mm	10 rods	20 x 10 rods
WEC1032	BlueStrike CASTCRAFT Electrodes 3.2mm	1kg	12kg - 12 x 1kg