

GGG

CATEGORY SMAW Stick Electrodes

TYPE High carbon and Silicon electrode for cast iron repairs

CLASSIFICATION
 AWS A 5.15:
 EN ISO 1071: EC FeC-2-7
 DIN 8573: E (FeC-2) BG 49

SUITABLE FOR Cast iron parts, Nickel free for colour matching grey cast Iron. Repair of non invisible blow holes etc.

APPROVALS CE approved

WELDING POSITIONS:



TYPICAL WELD DEPOSIT ANALYSIS (WEIGHT %)

C	Mn	Si	Ni
3.2	0.6	3.7	0.6

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
as welded		270					max 250

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-80			
3.2	350	80-140			
4.0	450	110-160			
5.0	450	150-210			

REDRYING TEMPERATURE 350°C/2hr