

GGG L

CATEGORY SMAW Stick Electrodes

TYPE Low carbon Nickel free elektrode for cast iron repairs

CLASSIFICATION
 AWS A 5.15: ~E St
 EN ISO 1071: EC St 1
 DIN 8573: ~E Fe1 / S21

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

WELDING POSITIONS:



FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Fe
0.2	0.7	0.1	rem

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
as welded							160-200

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (AC/DC+)	kg / can	kg / 6pack	kg / 1000
2.5	300	60-80			
3.2	350	90-110			
4.0	350	120-140			

REDRYING TEMPERATURE 180°C/1hr