



OK 92.58

SMAW

A nickel-iron-cored electrode for joining normal grades of cast iron, such as grey, ductile and malleable irons. It is also suitable for the rectification and repair of these grades and for joining them to steel. Deposition is performed on cold or slightly preheated cast iron. The weld metal is stronger and more resistant to impurities than the nickel-cored type.

Welding Current

AC, DC+ - OCV 50 V



PACKING/ORDERING INFORMATION				
Part Number	Dia (mm)	Inner Carton (kg)	Carton Weight (kg)	Pallet Weight (kg)
VacPac				
92582520K0	2.5	0.7	6.3	485.1
92583230K0	3.2	0.7	6.3	422.1
92584030G0	4.0	1.9	11.4	763.8

CLASSIFICATIONS	TYPICAL ALL WELD METAL COMPOSITION (%)		TYPICAL MECH. PROPERTIES ALL WELD METAL	
	<u>SFA/AWS A5.15</u> ENiFe-CI-A <u>EN ISO 1071</u> E C NiFe-CI-A 1	C	1.5	<u>Tensile Strength, Mpa</u>
	Si	0.7	375	
	Mn	0.8	<u>Hardness (HB), %</u>	
	Ni	51	180	
	Al	1.4		
	Fe	46		

WELDING PARAMETERS							
Diameter (mm)	Length (mm)	Welding Current, A	Arc Voltage, V	N. Kg Weld Metal/(kg) Electrodes	B. No. Of Electrodes/(kg) Weld Metal	H. Kg Weld Metal/(hour) Arc Time	T. Burn-off time, (secs)/ Electrode
2.5	300	55-75	21	0.70	90	0.6	70
3.2	350	75-100	23	0.70	45	0.9	90
4.0	350	85-160	24	0.70	30	1.8	70

