

CAST IRON WELDING WIRE

This Cast Iron Welding Wire is a composite metal cored wire for repair and joining of cast iron materials. The deposit, which is approximately 53% iron and 45% nickel, provides an excellent match for the coefficient of expansion exhibited by cast irons. It is also suitable for the fillet and butt welding of grey, malleable and SG irons to mild steel.

Shielding Gas

Argon + 1-3% O₂

Typical chemical composition of weld metal (wt%)

C	Mn	Si	Ni	Fe
1.4	1.8	0.7	44.2	Bal.

Typical mechanical properties of weld metal

Tensile strength MPa	Elongation %	Hardness Brinell (HB)
460	11	180-215

Packaging and Machine Settings

Diam. (mm)	1.2
Spool	2.27 kg
Volts	24-28
Current, A	180-250

Diam.	2.27 kg Spool
1.2mm	WCNI5512

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