

CACI 540

A specially designed “ Lo Temp” Medium coated electrode with Ferro-Nickel core wire for welding grey cast iron, malleable cast iron, nodular cast iron and joining these to other metals and difficult to weld cast iron parts. The chemistry is so formulated that the weld deposit remains tough and machinable. Machining is carried out with carbide tool. This electrode is very good for filling the foundry defects and gives perfect colour match.

Applications:

Joining and building up cracked, broken and damaged castings such as pump rotors, compressors, valves, pump casings and for filling up foundry defects.

Procedure :

Gouge / grind out cracks with bevel angles of 70-90⁰. Use the electrode on AC / DC – at lowest amperage. Deposit short, stringer beads with short arc. Peen the weld deposits while hot. Complete repairs at hand heat. Preheat is usually not necessary unless very heavy sections are involved.

Technical Data : CACI 540

Electrode size (mm), Ø	:	2.5	3.15	4.00	5.00
Welding current (AMPS)	:	45-75	75-110	100-140	130-170
Tensile strength	:	upto 35 kgf/mm ²			
Coating Colour	:	Black			
Tip colour	:	Silver.			

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