

CINOD 160

A low heat input, "LoTemp" nickel alloy electrode formulated for high strength welding of nodular iron. This "new alloy" electrode produces superior weld joints in grey, malleable, nodular (SG Iron) and alloy cast irons such as Ni-resists with exceptional crack resistivity, all position weldability and excellent machinability.

Applications:

Recommended for use on machine beds, pump casings, valve bodies, valve flanges, bell housings, motor covers, friction press discs etc. Especially suitable for superior penetration of contaminated surfaces, without the aid of a buffer layer.

Procedure:

Gouge / grind out cracks with bevel angles of 70-90°. Deposit short, stringer beads with short arc. Peen the weld deposits while hot. Complete repair at hand heat. Preheat is usually not necessary unless very heavy sections are involved.

<u>Technical Data</u>	:	CINOD 160			
Size (mm)	:	2.5	3.15	4.0	5.0
Recommended Welding Current (Amps)	:	60-90	90-120	120-150	150-200
Tensile Strength	:	35-40 kgf / mm ²			
Hardness	:	180-210 BHN			
Coating Colour	:	Black			
Tip Colour	:	Pale Rose			

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