

## CACI 150

Specially designed “Lo Temp” Medium coated electrode with Ferro-Nickel core wire for welding cast iron without preheating. Chemistry is so formulated that deposit does not pick up carbon, remains ductile, soft and machinable. This electrode is very good for filling the foundry defects, gives perfect colour match.

### Applications:

Filling foundry defects, for repairing cast iron components, correcting machine errors as well as buildup of worn out surfaces. Can be used for malleable iron, nodular graphite etc.

### Procedure:

Clean the surface and ensure that areas to be welded is free from grease, oil, dust, paint etc. For filling section use back step technique by depositing stringer beads. Peen the welded surfaces and remove the slag thoroughly. Care should be taken while welding. Use short bead to avoid over heating of the surface.

<b><u>Technical Data</u></b>	:	<b>CACI 150</b>			
Electrode size (mm), Ø	:	2.5	3.15	4.00	5.00
Welding current (AMPS)	:	40-70	70-110	90-120	140-180
Tensile strength	:	33 - 44 kgf/mm <sup>2</sup>			
Hardness	:	140 – 180 BHN			
Tip colour	:	Silver.			

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