

CACI 650

A new economical Nickel-Copper alloy low-Temperature electrode with a very smooth and stable arc giving shallow penetration for machinable welds on grey cast iron and also offers a better colour match than Ni (or) Ni-Fe alloys.

Applications:

For Filling up defects cast iron castings, rectification of welding errors, rebuilding missing sections, pumps bodies and rebuilding of cast iron forming dies.

Procedure:

Remove the casting skin of the parent metal. Guide the electrode at the steep angle playing the arc on the weld metal and keep the arc short. Reignite on the weld metal never on the parent metal. Weld at lowest possible current.

<u>Technical Data</u>	:	CACI 650			
Electrode size (mm), Ø	:	2.5	3.15	4.00	5.00
Welding current (AMPS)	:	40-75	75-100	100-130	130-160
Tensile strength	:	Upto 40 kgf/mm ²			
Tip colour	:	Silver			

DIFFUSION ENGINEERS LIMITED

Regd. Office & Works I : T-5/6, M.I.D.C, Hingna Industrial Area, Nagpur-440 016, (T) 091-7104-232084, 234727 (F) 232085

Works II : N-78/79, MIDC, Hingna Industrial Area, Nagpur – 440 016. (T) 091-7104-236036

Works II : T-12, MIDC, Hingna Industrial Area, Nagpur – 440 016.(T) 091-7104-232984

Email : info@diffusionengineers.com Website : www.diffusionengineers.com

Branch Offices : Chennai, Faridabad, Jamshedpur, Pune, Raipur, Secunderabad, Vadodara.