

CI-600

For repairing of cast iron products.

AWS A5.15 ESt
KS D 7008 DFCFe
JIS Z3252 ECSt

Applications

Repairing of various kinds of cast iron products.

Characteristics

CI-600 is a graphite type coated electrode, depositing weld metal consisting of pure iron. It is designed for welding of cast iron when machining of the deposit is not required. Hardness of the bonded area will be higher than that with nickel type electrode.

Notes on usage

- (1) Clean base metal before welding.
- (2) If there is a possibility that cracking spreads, make the stopholes at both ends of repairing part.
- (3) Keep bead length less than 50mm to disperse welding heat. Adopt back step, stepping stone or symmetry method by turns.
- (4) Hot peen in every pass.
- (5) The preheat temperatures vary in accordance with kind, shape and size of base metal. Preheating at 200~350°C is appropriate to prevent cracking. Slow cooling is recommended after welding.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S
1.34	0.47	0.65	0.02	0.005

Typical mechanical properties of weld metal

TS N/mm ² (kgf/mm ²)	EL %
510(50)	33

Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	
L (mm)	300	350	400	400	
Amp.	F	60-90	90-130	120-160	150-220

• Tip Color : Yellow