

Standards :

TS 9463 EN ISO 1071 :	EC Fe - 2
EN ISO 1071 :	EC Fe - 2

**Chemical Composition of Weld Metal-
% (Typical) :**

C	Mn	Si	V
0.07	1.0	0.8	8.0

Mechanical Properties :

Weld Metal Hardness (HB)
-250

Typical Base Material Grades :

* Repair of welding defects, for facing of worn-out parts of mold of automobile body, shielding process of metal frictioning works. * Good results at joint welding of steel with cast iron.
* Basic coated, Barium compound free, iron base, Vanadium alloyed cast iron electrode, which is used for repairing and maintenance of defective lamellar and nodular cast iron equipment and machine parts. Also used for hard face welding of wear susceptible of cast iron parts. Advantages of this Nickel free cast iron electrode is; "The deposit metal is a close color match to cast iron, "The similarity of chemical composition of weld metal and cast iron assures similar heat expansion and contraction characteristics, as a result there is no subject about thermal deformation." When welding, electrode is not hot, as a result welding can be done uninterrupted and more quickly. * Deposit of ELFER unlike those of Nickel base cast iron electrode, binding characteristic of enameling and pocolarizing operation in the same way does cast iron.

Welding Positions :



Current Type :

D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 350	3/32 x 12"	70 - 100	2350
3.20 x 350	1/8 x 12"	100 - 120	3600
4.00 x 350	5/32 x 16"	120 - 160	5260

Approvals :

TSE, CE, GOST-R, SEPRO