

REPTEC CAST 31 (Gricast 31)

TOP FEATURES

- The nickel-iron weld deposit is easily machineable
- Particularly applicable for nodular cast iron
- Hardness weld deposit ~ 180 HB

CLASSIFICATION

AWS A5.15ENiFe-CI

EN ISO 1071-AEC NiFe-CI 1

CURRENT TYPE

AC/DC-

WELDING POSITIONS

All position, except vertical down

APPROVALS

DB	
+	

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Fe	Ni
0.7	45	bal.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Hardness (HB10)
Required: AWS A5.5	AW	296-434	400-579	6-18	165-218
EN ISO 1071	AW	250	350	6	not specified
Typical values	AW	300	460	10	180

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	70-100
3.2 x 350	90-150
4.0 x 400	100-180

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOX	245	4.0	400915-2
3.2 x 350	CBOX	172	5.4	400922-2
4.0 x 400	CBOX	118	6.3	400939-2

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.