REPTEC CAST 3 (Gricast 3)

TOP FEATURES

- Basic graphite coated stick electrode with nickel iron core for cold welding of cast iron, malleable cast iron and joint welding to steel.
- Specially developed for good peen- and machinable seams e.g. for thick joints
- Recommended to weld with DC positive to introduce as little heat into the work piece as possible

TYPICAL APPLICATIONS

- Machine bases, pump bodies, engine blocks, gears and transmission housings.

CLASSIFICATION

AWS A5.15	ENiFe-CI
EN ISO 1071-A	E C NiFe-CI 1

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

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

	C	Fe	Ni
Min.	not specified	not specified	45.0
Max.	2.0	not specified	60.0
Typical	0.6	40	bal.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)	Hardness (HB10)
Required: AWS A5.5	AW	262-434	400-579	6-18	165-218
EN ISO 1071	AW	250	350	6	not specified
Typical values	AW	300	460	20	175

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-100
3.2 x 300	70-90
4.0 x 350	90-120

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CBOX	260	4.3	401035-2
3.2 x 300	CBOX	162	4.3	401042-2
4.0 x 400	CBOX	103	4.9	401059-2

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.