GRICAST 62

TOP FEATURES

- Basic graphite coated electrode with nickel copper core for welding and repair welding lamellar and spheroidal cast iron
- Welding of unalloyed steel to spheroidal cast iron
- Welding with DC+ results in the lowest dilution of the base material
- Thanks to the higher electrical conductivity by bimetal core, electrodes can be welded without interruption

TYPICAL APPLICATIONS

- Filling up of casting defects

CLASSIFICATION

AWS A5.15	ENIFE-CI*
EN ISO 1071	E C NIFE 2-1

* Nearest classification

CURRENT TYPE

AC/DC+

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	S	Ni	Fe
1.0	3.7	0.5	0.02	55	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	290	not specified	10	not specified
Typical values	AW	320	480	20	200

* AW = As welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
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
3.2 x 350	CBOX	162	5.0	99843235-2
4.0 x 400	CBOX	112	5.9	99844040-2

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: