



## MAC CAST E405

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■ **Description & Applications:**

Superior high quality fully machinable nickel electrode for joining and building up on cast irons. Builds up quickly and produces sound fully machinable deposits. Minimum base metal dilution. No undercut. For hot and cold welding of cast irons and for joining or building up on malleable iron, steels and copper or one to another. Ideal for foundry reclamation.

■ **Related Specification:**

AWS E Ni-Ci

■ **Typical All Weld Metal Chemical Analysis %:**

Ni	Mn
99.0	1.0

■ **Typical All Weld Metal Mechanical Properties:**

**As Welded**

Ultimate Tensile Strength	340 N/mm <sup>2</sup>
Elongation	15%
Hardness	170 Brinell

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
30-75	70-100	100-150	120-190

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.