



MAC CAST E406

■ **Description & Applications:**

High quality general purpose nickel electrode designed for economical joining and surfacing of cast iron. Positive arc, fast build-up, easy slag detachability and fully machinable porosity free welds. May be used for hot or cold welding of cast irons and for surfacing and building up on malleable irons. It is suitable for joining mild steel to cast iron and is ideal for maintenance repair where sound welds are required.

■ **Related Specification:**

AWS E Ni-Ci

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

Ni	Fe	Mn
97.0	1.0	2.0

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

As Welded

Ultimate Tensile Strength	415 N/mm ²
Elongation	15%
Hardness	180 Brinell

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
50-80	80-100	120-170	170-200

■ **Storage:**

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