



MAC CAST E407

■ **Description & Applications :**

High strength nickel iron machinable electrode for joining and building up on cast irons. Low amperage, smooth arc, minimum spatter and high resistance to cracking. Due to Bi-metallic core wire this product gives excellent current carrying capacity which will prevent overheating. For the repair of grey, S.G., nodular or ductile irons where higher strength is required, also suitable for the joining of cast iron to mild steel.

■ **Related Specification:**

AWS E Ni-Fe-Ci

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

| | |
|------|------|
| Ni | Fe |
| 55.0 | 45.0 |

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

As Welded

| | |
|---------------------------|-----------------------|
| Ultimate Tensile Strength | 448 N/mm ² |
| Elongation | 20% |
| Hardness | 180 Brinell |

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

| | | | |
|--------|--------|---------|---------|
| 2.50mm | 3.25mm | 4.00mm | 5.00mm |
| 40-70 | 70-110 | 110-150 | 130-170 |

■ **Storage:**

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