MAC CAST E407S

Description & Applications :

Manufactured on a pure nickel core wire with an extruded basic flux containing both graphite and a high metallurgical grade of iron powder. Welds with a soft stable arc and ensures a metal recovery of 160% with respect to core wire.
Designed for welding all grades of cast iron to steel. The advanced deoxidisation system ensures the maximum combination of weld strength, ductility and machinability. The design principle of the electrode prevents overheating and provides great resistance to porosity.

Related Specification:

AWS E Ni-Fe-Ci

Typical All Weld Metal Chemical Analysis %:

C	Mn	Si	S	P	Ni	Fe
0.90	1.10	0.60	0.010	0.009	55.00	44.00

Typical All Weld Metal Mechanical Properties:

As Welded

Ultimate Tensile Strength	410 N/mm²
0.2% Proof Stress	230 N/mm²
Elongation on 4d	15%
HV10	240

Current:

AC/DC (+)

Sizes Available and Recommended Amperages:

2.50mm	3.25mm	4.00mm	5.00mm
70-100	100-130	140-190	180-220

Storage:

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

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