



MAC CAST E409

■ **Description & Applications:**

Fully machinable nickel based electrode with specially developed non-conductive coating for welding most cast irons. Specially designed for use where awkward and confined spaces cause arcing difficulties. May be used for hot or cold welding of most types of cast iron.

■ **Related Specification:**

AWS E Ni-Ci
Non Conductive

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

Ni	Mn
99.0	1.0

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

As Welded

Ultimate Tensile Strength	400 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	90-110	110-140	140-180

■ **Storage:**

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