

Cast Iron

Product Name Classification AWS Classification EN Classification DIN	Mechanical Properties Typical Values	Size (mm)	Approvals	Characteristics and Applications
UTP N 815 C	UTS: 350 MPa	2.50 x 350 3.15 x 350 4.00 x 350	-	<p>UTP N 815 C is Nickel electrode suitable for welding of grey and malleable cast iron, cast steel and especially for repair and maintenance. This electrode has excellent welding properties with smooth bead, easy slag removal and minimum spatter.</p> <p>Superior for thin walled grey cast iron.</p> <p>Excellent for building up missing sections, cladding, filling holes, repairing broken, cracked and fabrication of cast iron to other metals. Suitable for vertical and overhead work.</p> <p>Outstanding features are -</p> <ul style="list-style-type: none"> • Ideal for cladding application • Minimal base metal penetration and dilution <p>Applications: Engine blocks (water jacket), cast iron gears and pulleys, sliding tables for machine tools.</p>
UTP N 819 FN	UTS: 430 MPa YS: 380 MPa	2.50 x 350 3.15 x 350 4.00 x 350	-	<p>UTP N 819 FN is Ferro Nickel electrode with approx. 55% Ni in weld metal suitable for joining and surfacing lamellar grey cast iron, nodular cast iron and malleable cast iron as well as for joining these materials with each other or with steel or cast steel. Applicable for repair, construction and production welding.</p> <p>It has excellent buttering characteristic on cast iron. This electrode has stable arc and produces a flat seam structure without undercutting. The bead appearance is smooth. The weld deposit is highly crack resistant and easily machinable with cutting tools.</p> <p>The current carrying capacity and the deposition rate are excellent.</p> <p>Applications: Nodular Iron castings, housings, foundry defects, cast iron die cladding and build-up</p>
UTP N 817	-	2.50 x 350 3.15 x 350 4.00 x 350	-	<p>UTP N 817 is non machinable cast iron electrode suited for pickup layers on poorly weldable cast iron as a base for a secondary weld with pure Nickel or Ferro Nickel stick electrode. Wear surfacing can also be performed with one pass weld.</p> <p>For all cast iron repair welding not requiring machining. Weld metal cracking tendencies are greatly minimized. Nickel free deposits and its colour matches with cast iron. Suitable for all types of sections, thick and thin and for joining of cast iron to steel.</p> <p>Applications: Sealing oil-soaked cast iron parts, defects, cast iron furnace equipment.</p>

