

# CARBOCAST X

<b>International standards</b>	DIN 8573	E Ni BG 13
	ISO 1071	ENi
	AWS A5.15	ENi-CI

**Approvals** ---

**Typical applications and characteristics**

Basic-graphite Barium free non conductive coating, electrode with a pure nickel core wire. Suitable for cold welding on grey cast iron, malleable cast iron, and cast steel as well as repair welding on castings showing symptoms of fatigue.  
Especially designed to weld in deep holes or on parts where the coating may touch the casting .  
Excellent welding properties also for welding with low amperage. Homogeneous and easy to machine deposit. Good bonding and flow of the weld metal. Repairing of engine blocks, frames of tool machines, Gearboxes, reducing pieces, valve and pumps bodies.

<b>Base materials</b>	Grey cast iron to different steels :		
	<b>ASTM</b> A48 Class 25B – A48 Class 60B	<b>DIN</b> GG-15 to GG-40	<b>NFA</b> FGL 150 to FGL 400

**Welding instructions/** Thoroughly clean the surface of the work-piece make sure it is exempt from grease (previous grinding). When welding on cast iron, heat input should as low as possible.  
The bead must not be wider than twice the core wire diameter and not be longer than ten times the core wire diameter. To limit internal stress of the base metal, hammering of the beads is recommended after each pass.

<b>Mechanical properties of all-weld metal ( typical values )</b>	<b>Tensile strength</b> <b>R<sub>m</sub> N/mm<sup>2</sup></b>	<b>Hardness</b> <b>HB</b>
	>300	approx. 170

<b>Weld metal analysis (typical, wt. %)</b>	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Fe</b>	<b>Cu</b>	<b>Ni</b>
	0,6	0,5	0,2	6	0,6	base

**Current** = +, ~ 50 V

**Welding positions** PA, PB, PC, PD, PE, PF, PG

**Rebaking** 1 h, 120 °C +/- 10 °C ( if required )

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/ packet	kg/ carton
2,5 x 350	55 - 80	250	1000	20,0	5,0	20,0
3,2 x 350	80 - 110	147	590	33,9	5,0	20,0
4,0 x 350	100 - 140	97	390	51,3	5,0	20,0

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