

EXCEL CAST 423



TYPICAL APPLICATION

Machine Tool bases, Valve body, Pumps, Gear boxes, Gear teeth, Sprockets, Coupling, piping, Transmission housings etc.

PRODUCT FEATURES

1. Dense deposits with excellent machinability.
2. High Tensile strength and ductility.
3. Innovative design that offers excellent weldability with SG iron.
4. Maximum resistance to cracking.

RECOMMENDATIONS

Joining of cast irons and cast iron to steels of similar/ dissimilar thickness. Repair welding of high strength, heavy duty ductile irons involving massive sections and for joints under restraints.

PROCEDURE

Clean the weld area from grease & other contaminations. Preheat part up to 250°C, if necessary. Always use short & medium arcs while welding. Avoid the excessive heat locally, hence skip welding is highly recommended. Remove slag between passes. Allow cooling slowly. Peen lightly to remove stresses.

RECOMMENDED AMPERAGES

SIZE (mm)	AMPERAGE
4.00	110 – 130
3.15	95 – 110
2.50	60 – 75

TECHNICAL DATA

1. Current: AC/DC +
2. Tensile Strength: 57,000 psi
3. Machinability: Very Good

Mfd. By EXCEL CRAFT PVT. LTD. (WELDING DIVISION)

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