

Low Heat Input Electrodes for Cast Iron

'Valency' manufactures excellent Low Heat Input cast Iron Electrodes ,both machinable and non- machinable types. The Electrodes have superb Welding Characteristics



ISO 9001-2008

PRODUCT CATALOGUE FOR Cast Iron



B . ELECTRODE FOR CAST IRON														
Product	Description	Applications	Typical Properties	Size and Current										
VALMET 26 [AC/DC+]	SPRAY TRANSFER, NON MACHINABLE WELD FOR RUSTY, CORRODED, OIL SOAKED IRON PARTS	machine frames, oil pump, pump housing, foundry defects	U.T.S. 380-430 N/mm ²	<table border="1"> <tr> <td>Size (mm)</td> <td>2.50</td> <td>3.15</td> <td>4.0</td> <td>5.0</td> </tr> <tr> <td>Amps</td> <td>50-70</td> <td>60-110</td> <td>80-130</td> <td>100-170</td> </tr> </table>	Size (mm)	2.50	3.15	4.0	5.0	Amps	50-70	60-110	80-130	100-170
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CASTOMAC 238 [AC/DC+]	NODULAR IRON CASTING, CAST IRON TO M.S. JOINING WITH HIGH CARCK RESITIVITY, MACHINABLE WELD GIVING GOOD COLOUR MATCH	Repair of welding defects of heavy castings sections, pump casing, engine head, valve bodies, motor body, foundry defects cladding.	U.T.S. 380-420 N/mm ² , Hardness 190-210 B.H.N.	<table border="1"> <tr> <td>Size (mm)</td> <td>2.50</td> <td>3.15</td> <td>4.0</td> <td>5.0</td> </tr> <tr> <td>Amps</td> <td>50-70</td> <td>60-110</td> <td>80-130</td> <td>100-170</td> </tr> </table>	Size (mm)	2.50	3.15	4.0	5.0	Amps	50-70	60-110	80-130	100-170
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MPCI 228 [AC/DC+]	HIGH STRENGTH NICKEL IRON ALLOY ELECTRODE FOR CAST IRON TO M.S. JOINING WITH HIGH CARCK RESITIVITY, MACHINABLE DUCTILE WELD	Pump casing, engine head, valve bodies, motor body, foundry defects, auto parts, cladding, heavy cast iron sections	U.T.S. 350-400 N/mm ² ,	<table border="1"> <tr> <td>Size (mm)</td> <td>2.50</td> <td>3.15</td> <td>4.0</td> <td>5.0</td> </tr> <tr> <td>Amps</td> <td>50-70</td> <td>60-110</td> <td>80-130</td> <td>100-170</td> </tr> </table>	Size (mm)	2.50	3.15	4.0	5.0	Amps	50-70	60-110	80-130	100-170
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CASTODYNE 2384 C [AC/DC+]	SUPERIOR WELDABILITY & MACHINABILITY RECOMMENDED FOR PATCHING UP WELDING DEFECTS WITH EXCELLENT COLOUR MATCHING	Cast Iron roll & other foundry defect rectification, cast iron die cladding & for nodular iron	U.T.S. 380-430 N/mm ²	<table border="1"> <tr> <td>Size (mm)</td> <td>2.50</td> <td>3.15</td> <td>4.0</td> <td>5.0</td> </tr> <tr> <td>Amps</td> <td>40-70</td> <td>60-110</td> <td>80-130</td> <td>100-170</td> </tr> </table>	Size (mm)	2.50	3.15	4.0	5.0	Amps	40-70	60-110	80-130	100-170
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Product	Description	Applications	Typical Properties	Size and Current				
CASTODYNE 2386 [AC/DC+]	EXCELLENT BONDING & MACHINABILITY, VERY HIGH CRACK RESISTANCE, MAXIMUM WELD SOUNDNESS	Cast Iron roll & other foundry defect rectification, cast iron die cladding & for nodular iron	U.T.S. 380-420 N/mm ²	Size (mm)	2.50	3.15	4.0	5.0
				Amps	40-70	60-110	80-130	100-170
MPCI 220 [AC/DC+]	SOFT & DUCTILE HIGH NICKEL ELECTRODE	Cast iron gears & pulleys, housing, machine bases, engine blocks (water jacket), filling up blow holes etc.	U.T.S. 350-380 N/mm ² .	Size (mm)	2.50	3.15	4.0	5.0
				Amps	40-70	60-110	80-130	100-170
SDM 240 [AC/DC+]	STRONG, DUCTILE & MACHINABLE REPAIR OF CAST IRON PARTS	For filling, joining, building up & repair of castings, sugar mill rollers, cast iron gears & pulleys, housing, machine bases, engine blocks (water jacket), filling up blow holes etc.	U.T.S. 330-400 N/mm ² . Hardness: 140-170 BHN	Size (mm)	2.50	3.15	4.0	5.0
				Amps	50-70	60-110	80-130	100-170
SDM 250 [AC/DC+]	VERY HIGH NICKEL ALLOY, MINIMAL BASE METAL DILUTION, VERY SOFT & DUCTILE DEPOSIT.	Foundry Castings, sugar mill rollers, cast iron gears & pulleys, housing, machine bases, engine blocks (water jacket), filling up blow holes etc.	U.T.S. 320-380 N/mm ² , Hardness 110-130 BHN	Size (mm)	2.50	3.15	4.0	5.0
				Amps	50-70	60-110	80-130	100-170
CASTO SUPER 0077 [AC/DC+]	ONE ELECTRODE FOR ALL TYPES OF CAST IRON. SUPERB WELDABILITY, MAXIMUM CRACK RESISTANCE, EXCELLENT WELDABILITY	A versatile electrode for all Foundry Castings, sugar mill rollers, cast iron gears & pulleys, housing, machine bases, engine blocks (water jacket), filling up blow holes etc.	U.T.S. 320-400 N/mm ² , Hardness 130-170 BHN	Size (mm)	2.50	3.15	4.0	5.0
				Amps	50-70	60-110	80-125	110-170