



# NEXA-224

## ELECTRODE FOR COLD WELDING OF CAST IRON.

**ALLOY BASE : Ni.**

### SPECIAL FEATURES

- Exceptional weldability.
- High nickel content.
- Weld deposits exhibit high strength and machinability.
- All positional welding alloys.
- It is a unique product for heavy section, structure and casting of big machineries of cast iron.

### RECOMMENDATIONS

Recommended for joining and build – up of malleable iron and grey cast iron without preheat. It is used for heavy sections dissimilar thickness circumferential pipe joints can be welded effectively.

### APPLICATIONS

A unique electrode for cold welding of cast iron without preheats and joining cast iron parts subjects to erosion, corrosion and high temperatures. Best suited for repairing intricate cast iron part, waters pump housing, electric motor bodies and covers, machine frames, cylinder blocks, gears. Also ideal for salvaging foundry casting, gear box and differential housing, lathe beads, sugar mill rollers, glass moulds and cast iron dies.

### PROCEDURES

Clean the welding zone and check the surface for cracks and defects. Use a short arc with low current to deposit a string bead not exceeding 50 mm. Peen the deposits to reduce residual stresses.

### TECHNICAL DATA

Tensile Strength : 30-34 kgf / mm<sup>2</sup>  
Hardness 100 – 130 BHN

### CURRENT RANGE : DC (-)

SIZE mm	2.50	3.15	4.00
CURRENT (Amps)	40-70	60-110	100-120